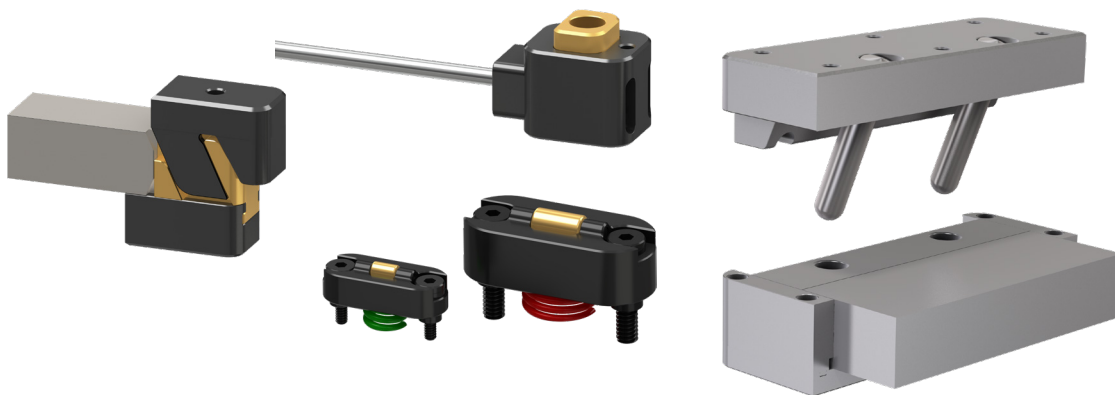




SLIDE COMPONENTS CAMACTIONS

SECTION G



CamAction 100 Series	CamAction 200 Series	CamAction 250 Series	CamAction 300/350 Series
Prefix: CA, CAMM	Prefix: CA, CAMM	Prefix: CA	Prefix: CA, CAMM
Page: G-2	Page: G-3	Page: G-4	Page: G-5 - G-8



CamAction 400 Series	CamAction Accessories	Versa-Slides: 10/20 Series	Versa-Slides: 30-60 Series
Prefix: CA	Prefix: CAP, CSE	Prefix: SL-10 & SL-20	Prefix: SL
Page: G-9	Page: G-10 - G-13	Page: G-15 & G-16	Page: G-17 - G-21



Versa-Slides: Slide Faces	Slide Retainers & Cleats	SRT Bases & Bushings	SRT Slide Locks & Cleats
Prefix: SLF	Prefix: SRT, SRTM	Prefix: SRTBA, SRTBU	Prefix: SRTLK
Page: G-22 & G-23	Page: G-24	Page: G-26	Page: G-27



Square Gibs	Center Guides	Wear Strips	Wear Plates
Prefix: SG	Prefix: CG	Prefix: WS	Prefix: WP
Page: G-28	Page: G-29	Page: G-30	Page: G-31



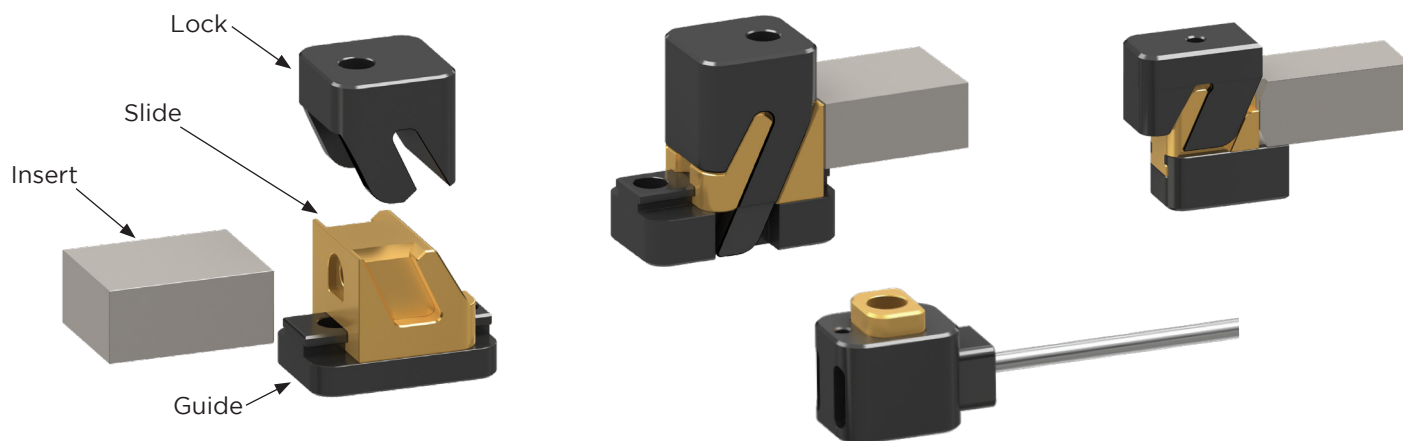
Wear Plates: Bronze	L-Gibs (Bronze)	Angle Pins	Angle Pin Holders
Prefix: WP	Prefix: CLGIB	Prefix: AP	Prefix: APH
Page: G-32	Page: G-32	Page: G-33	Page: G-34



CAM ACTION® ASSEMBLIES SELECTION GUIDE

Progressive's CamActions provide easy installation for molding and releasing details. Several sizes and travel configurations are available.

- Advanced materials and treatments for long-lasting production.
- Inserts and pins available in all series.
- For application assistance, please contact tech@procomps.com.



Inch Standard

TRAVEL	OVERALL ASSEMBLY SIZES	CATALOG NUMBER	CAMACTION SERIES	PAGE NUMBER
.160"	1.00" X 1.25" X 1.00" H	CA-100	100 Series	G-2
.230"	1.00" X 1.25" X 1.50" H	CA-200	200 Series	G-3
.230"	1.00" X 1.25" X 4.12" H	CA-200L*		
.150"	.50" X .75" X 1.25" H	CA-250-15	250 Series	G-4
.310"	.80" X 1.38" X 1.75" H	CA-250-31		
.500"	1.25" X 2.00" X 2.75" H	CA-250-50		
.250"	1.50" X 2.25" X 2.25" H	CA-300	300 Series	G-5
.250"	1.50" X 2.25" X 5.79" H	CA-300L*		
.750"	1.50" X 2.63" X 2.63" H	CA-350	350 Series	G-7
1.000"	3.00" X 4.00" X 4.44" H	CA-400	400 Series	G-9

L= Longer Driver or Lock to extend below parting line.

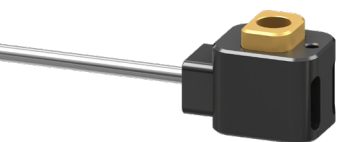
Metric Standard

TRAVEL	OVERALL ASSEMBLY SIZES	CATALOG NUMBER	CAMACTION SERIES	PAGE NUMBER
4mm	26 X 32 X 25.4 H	CAMM-100	100 Series	G-2
5.8mm	26 X 32 X 38.1 H	CAMM-200	200 Series	G-3
5.8mm	26 X 32 X 103.2 H	CAMM-200L*		
4mm	12 X 20 X 32 H	CAMM-250-4	250 Series	G-4
8mm	20 X 34 X 47 H	CAMM-250-8		
12mm	32 X 50 X 68 H	CAMM-250-12		
6.35mm	40 X 60 X 57.7 H	CAMM-300	300 Series	G-6
6.35mm	40 X 60 X 147.4 H	CAMM-300L*		
18mm	40 X 64 X 66.5 H	CAMM-350	350 Series	G-8

L= Longer Driver or Lock to extend below parting line.

CAM ACTION®

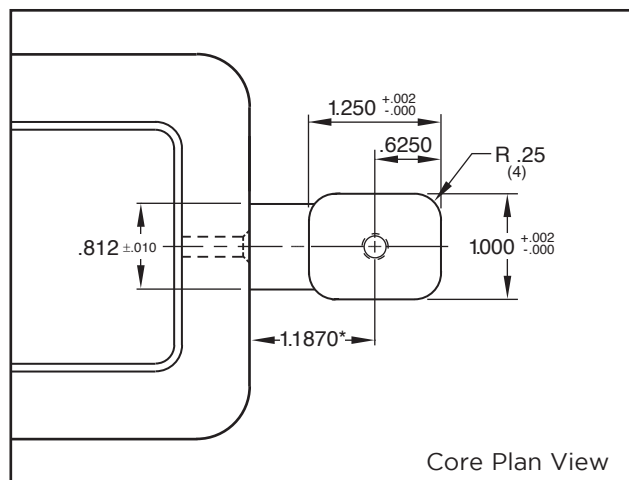
100 SERIES



APPLICATION GUIDELINES

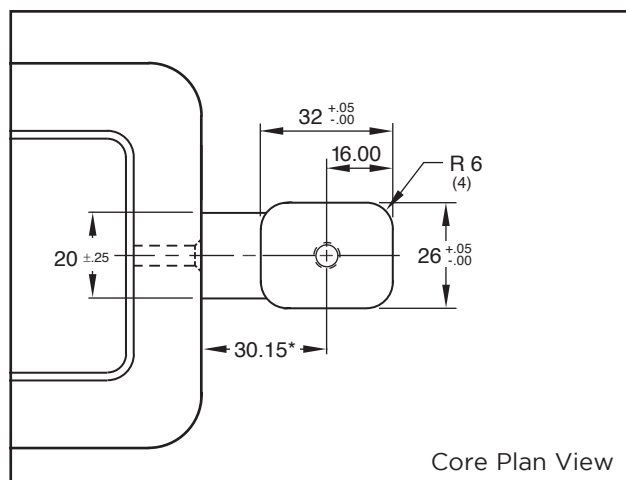
- Travel = .160" (4mm)
- Max operating temperature 300°F (150°C)
- Core Pins (sold on page G-10) are to be fully supported in the core as shown.

Inch Standard

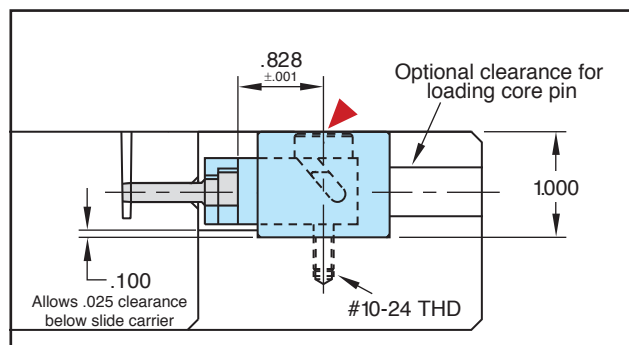


When the core pin is not shutting off on the inner core wall, the distance from the edge of the insert should be 1.142 for the slide carrier to shut off against the core insert.

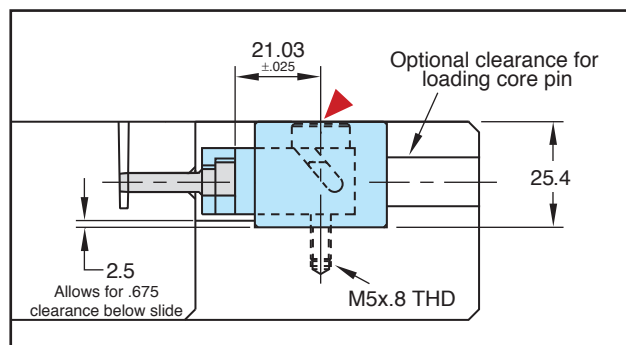
Metric Standard



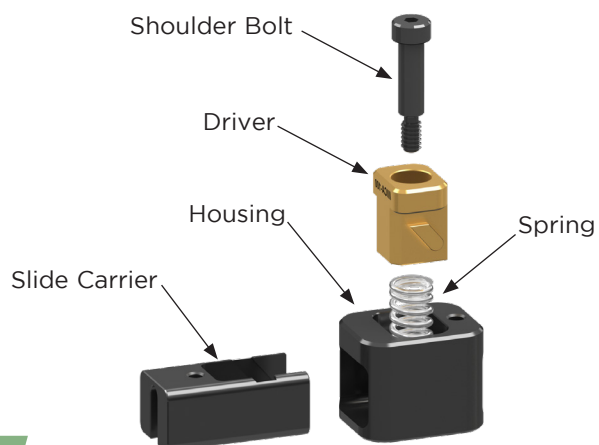
When the core pin is not shutting off on the inner core wall, the distance from the edge of the insert should be 29.00 for the slide carrier to shut off against the core insert.



The .828 dimension must be maintained to avoid improper spring pre-load or damage to internal components.



The 21.03 dimension must be maintained to avoid improper spring pre-load or damage to internal components.



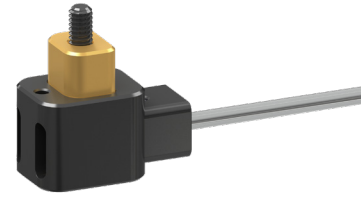
► CAD insertion point

CATALOG NUMBER	DESCRIPTION
CA-100	CamAction Unit
CAMM-100	Metric CamAction Unit

PART NAME	MATERIAL/TREATMENT
Driver	H-13, 40-44 HRC, Titanium Nitride
Slide Carrier	P-20, 30-34 HRC, Black Nitride
Housing	4140, 28-32 HRC, Black Nitride



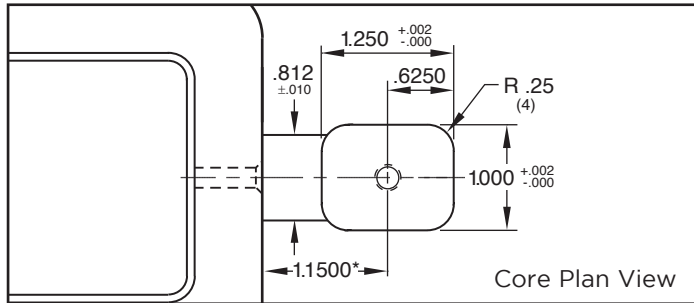
CAM ACTION® 200 SERIES



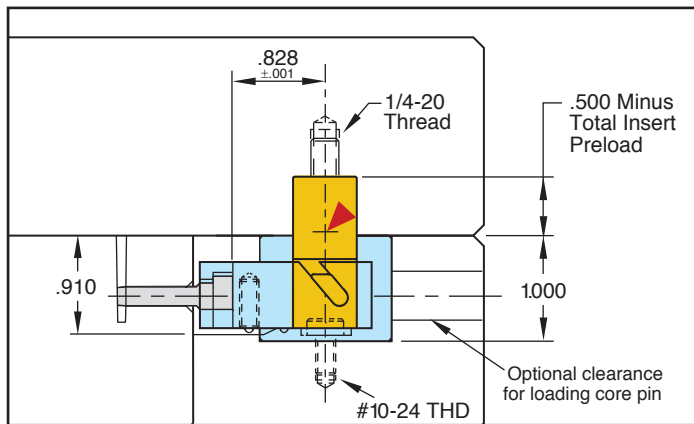
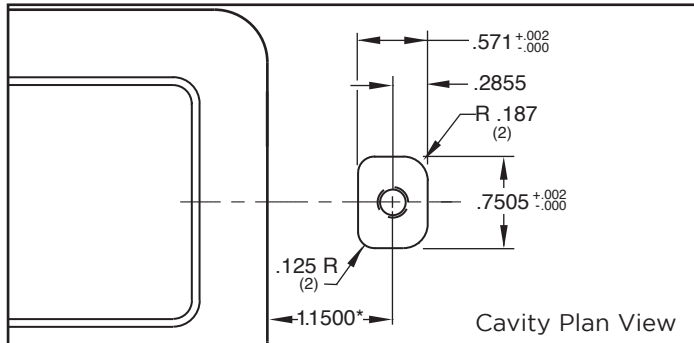
APPLICATION GUIDELINES

- Travel = .230" (5.8mm)
- Longer driver allows for extension below parting line up to 3" (76mm).
- Max operating temperature 480°F (250°C)
- Core Pins and Inserts (on page G-10) are to be fully supported in the core as shown.

Inch Standard

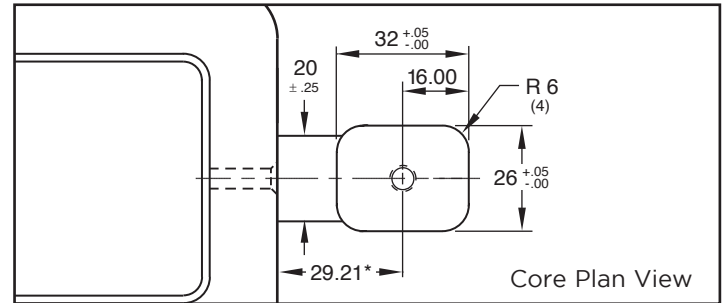


When the core pin is not shutting off on the inner core wall, the distance from the edge of the insert should be 1.1425 for the slide carrier to shut off against the core insert.

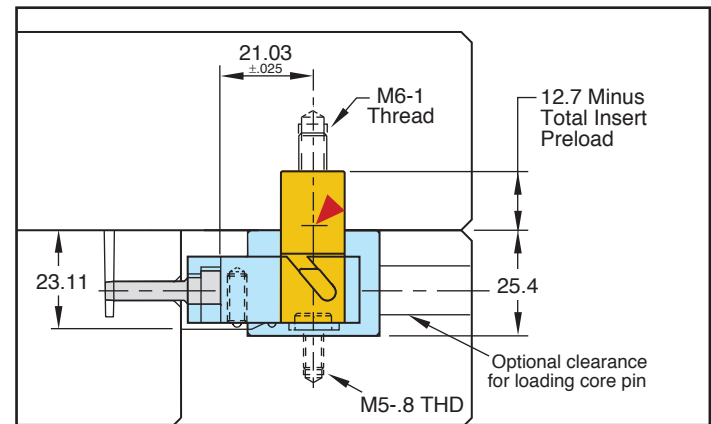
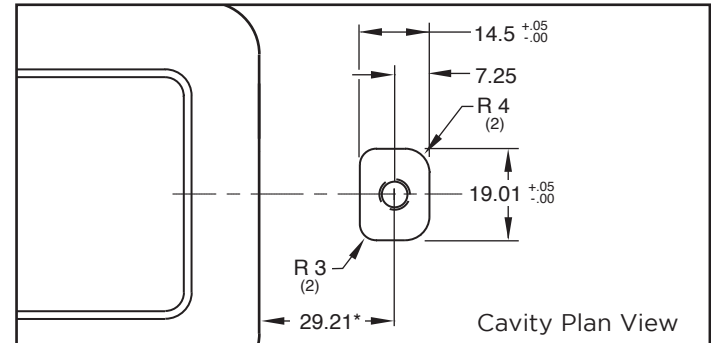


The .828 dimension must be maintained to ensure proper shut-off.

Metric Standard



When the core pin is not shutting off on the inner core wall, the distance from the edge of the insert should be 29.02 for the slide carrier to shut off against the core insert.

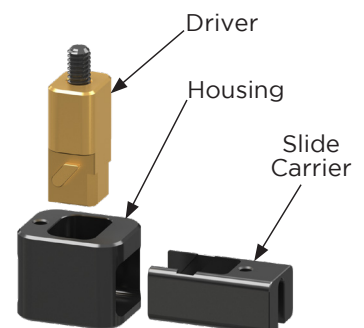


The 21.03 dimension must be maintained to ensure proper shut-off.

► CAD insertion point

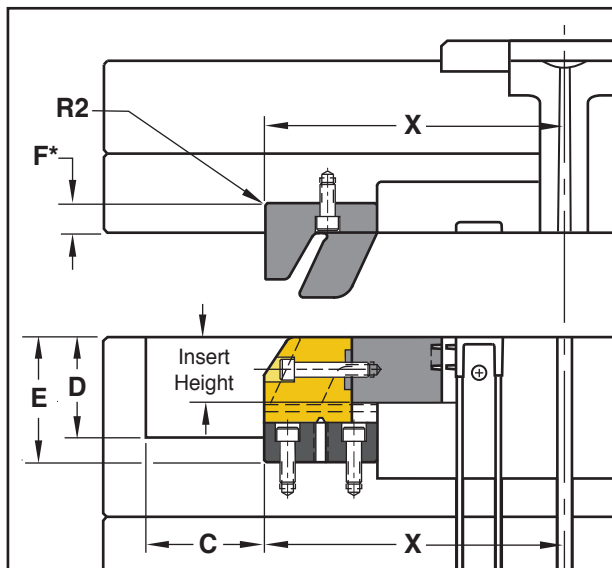
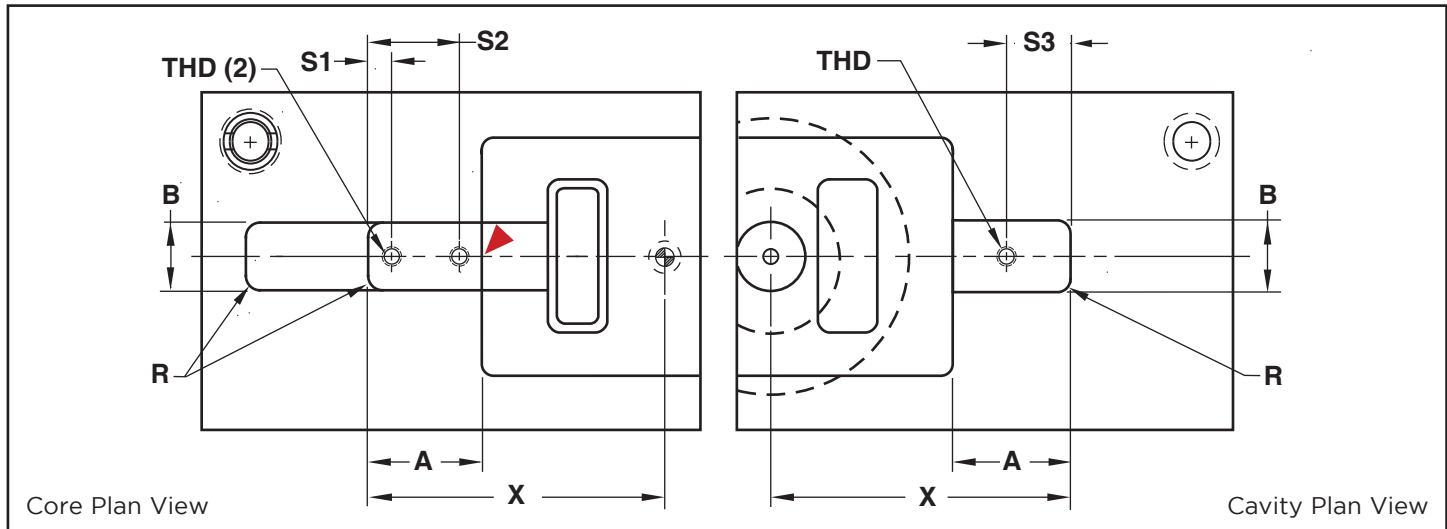
CATALOG NUMBER	DESCRIPTION
CA-200	CamAction Unit-Standard Driver
CA-200L	CamAction Unit-Longer Driver
CAMM-200	Metric CamAction Unit-Standard Driver
CAMM-200L	Metric CamAction Unit-Longer Driver

PART NAME	MATERIAL/TREATMENT
Driver	H-13, 40-44 HRC, Titanium Nitride
Slide Carrier	P-20, 30-34 HRC, Black Nitride
Housing	4140, 28-32 HRC, Black Nitride

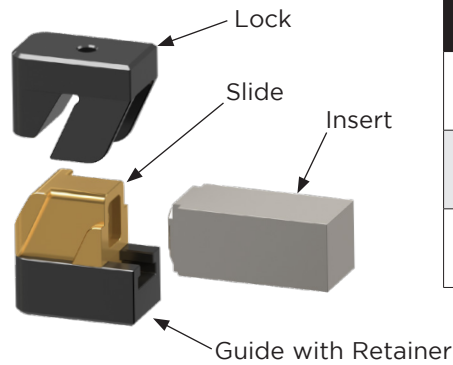


CAM ACTION®

250 SERIES

 CAD insertion point


*Minus pre-load.



PART NAME	MATERIAL/TREATMENT
Lock	H-13, 48-50 HRC, Black Nitride
Slide	H-13, 46-48 HRC, Titanium Nitride
Guide	H-13, 48-50 HRC, Black Nitride

APPLICATION GUIDELINES

- Machine pockets from the common location "X" to the dimensions shown.
- Slide Retainers (SRT-10/SRTM-04) are installed in the slides on the CA-250-50/CAMM-250-12. Ball Plungers retain the slide in the other sizes.
- Max operating temperature 480°F (250°C).
- Inserts are sold separately on page G-11.

Inch Standard

CATALOG NUMBER	TRAVEL	A	B	C MINIMUM CLEARANCE	D MINIMUM CLEARANCE	E	F	S1 ±.01	S2 ±.01	S3 ±.01	R	R2	THD
CA-250-15	.15	.750	.500	.63	.60	.937	.313	.15	.59	.43	1/8	.03	#4-40 x 3/8
CA-250-31	.31	1.375	.800	1.03	1.03	1.375	.375	.31	1.06	.75	3/16	.03	#8-32 x 7/16
CA-250-50	.50	2.000	1.250	1.50	1.90	2.125	.625	.37	1.62	1.12	1/4	.04	1/4-20 x 5/8

Socket Head Cap Screws (3) included.

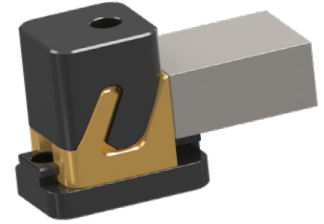
Metric Standard

CATALOG NUMBER	TRAVEL	A	B	C MINIMUM CLEARANCE	D MINIMUM CLEARANCE	E	F	S1 ±.25	S2 ±.25	S3 ±.25	R	R2	THD
CAMM-250-4	4	20	12	17	16	24	8	4	16	10	3	.4	M3-.5 x 10
CAMM-250-8	8	34	20	27	27	38	9	7	27	19	4	.4	M4-.7 x 12
CAMM-250-12	12	50	32	39	38	53	15	10	40	27	5	1.0	M6-1 x 18

Socket Head Cap Screws (3) included.

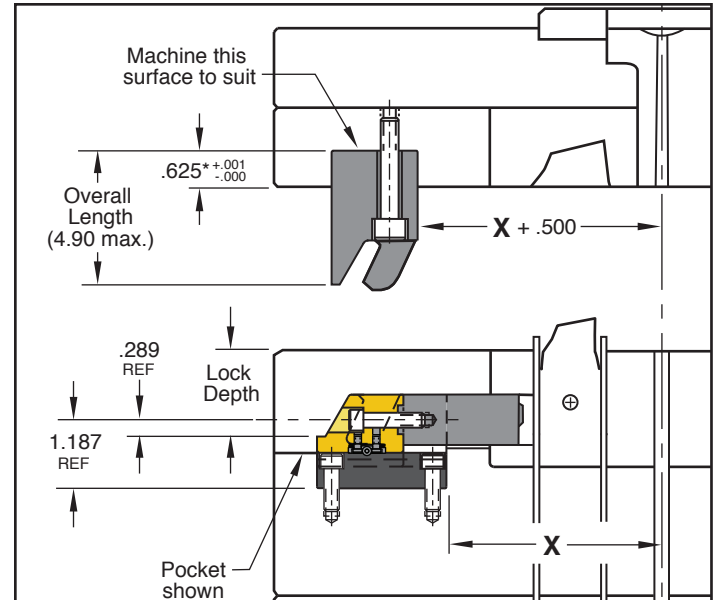
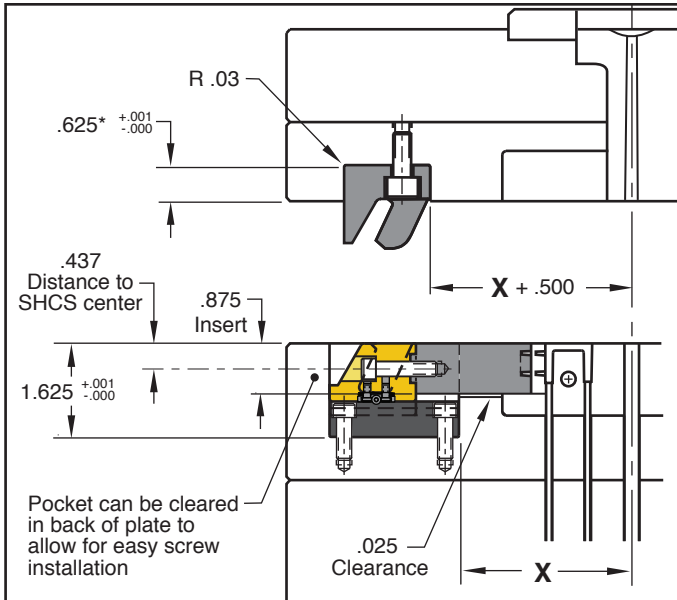
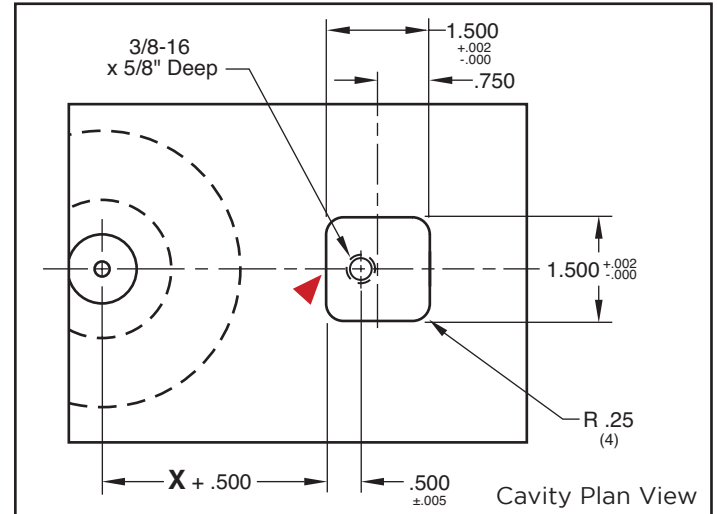
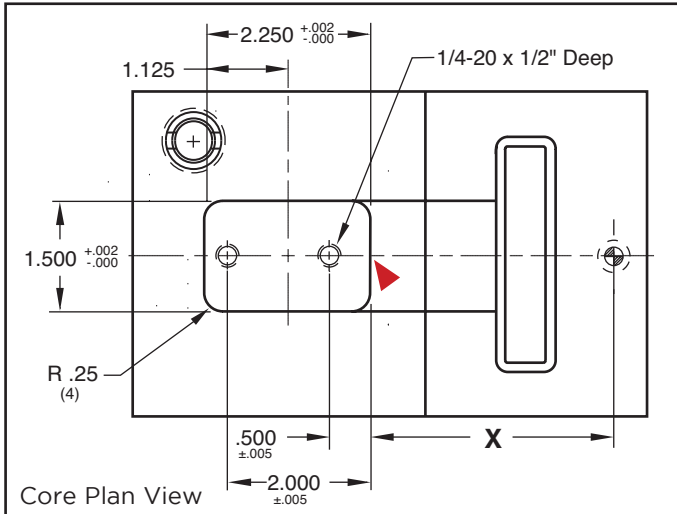


CAM ACTION® 300 SERIES: INCH STANDARD

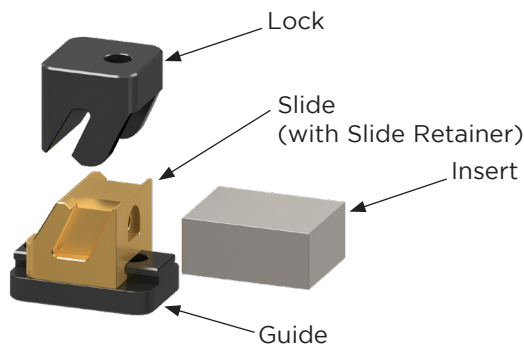


APPLICATION GUIDELINES

- Travel = .250"
- Each assembly includes SRT-10 Slide Retainer and (3) mounting screws.
- Max operating temperature 425°F (220°C).
- Core Pins and Inserts are sold separately on page G-12.



*Minus pre-load.

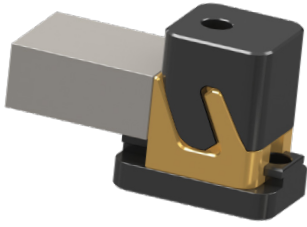


▶ CAD insertion point

CATALOG NUMBER	DESCRIPTION
CA-300	CamAction Unit-Standard Lock
CA-300L	CamAction Unit-Longer Lock
PART NAME	MATERIAL/TREATMENT
Lock	H-13, 40-44 HRC, Black Nitride
Slide	H-13, 40-44 HRC, Titanium Nitride
Guide	4140, 28-32 HRC, Black Nitride

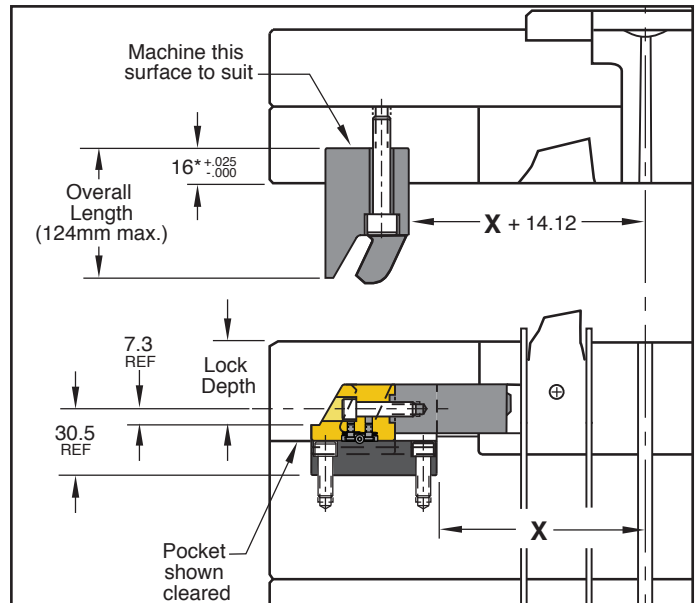
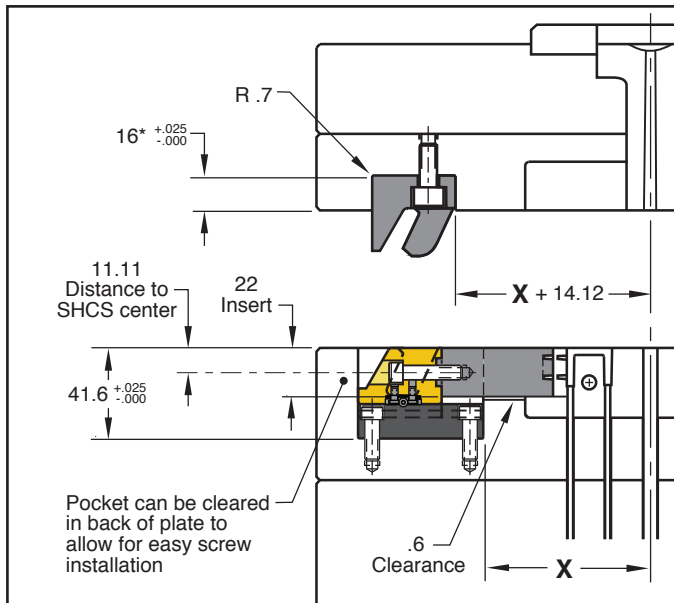
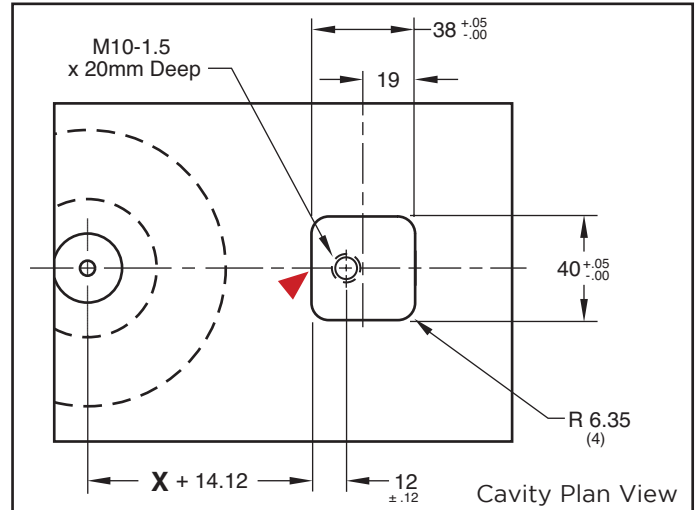
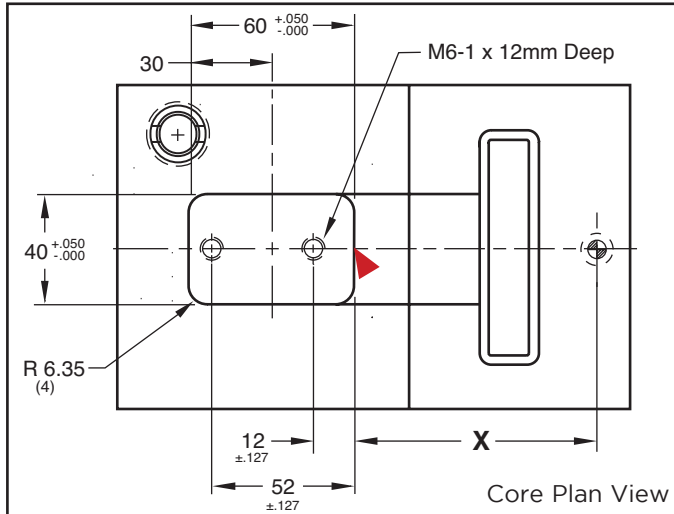
CAM ACTION®

300 SERIES: METRIC STANDARD

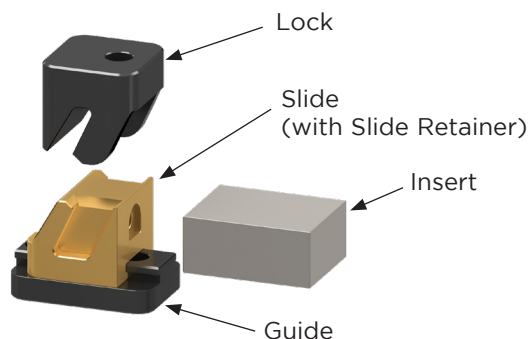


APPLICATION GUIDELINES

- Travel = 6.35mm
- Each assembly includes SRTM-04 Slide Retainer and (3) mounting screws. Core Pins and Inserts are sold separately on page G-12.
- Max operating temperature 425°F (220°C).
- See page G-5 for materials and treatments.



*Minus pre-load.



▶ CAD insertion point

CATALOG NUMBER	DESCRIPTION
CAMM-300	Metric CamAction Unit-Standard Lock
CAMM-300L	Metric CamAction Unit-Longer Lock

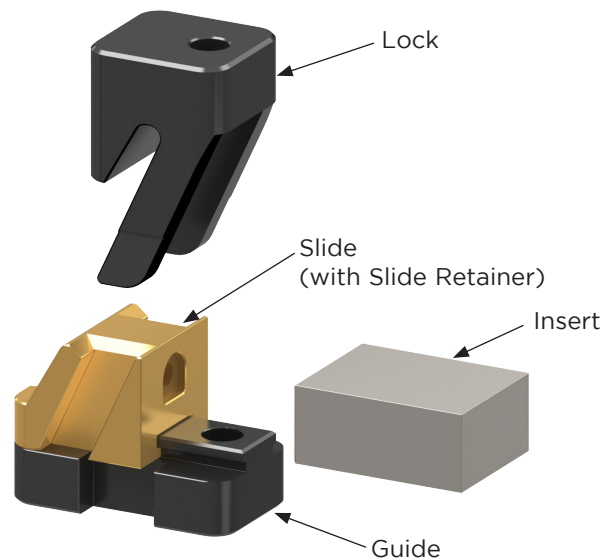
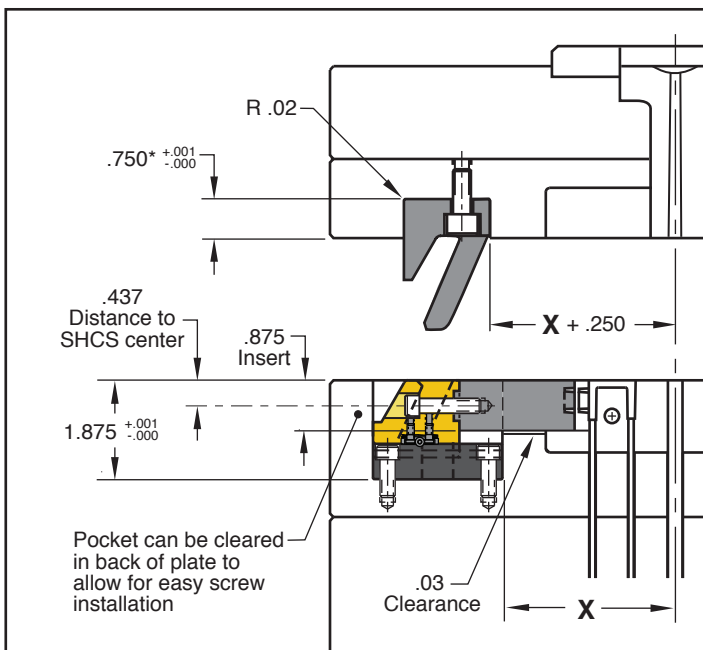
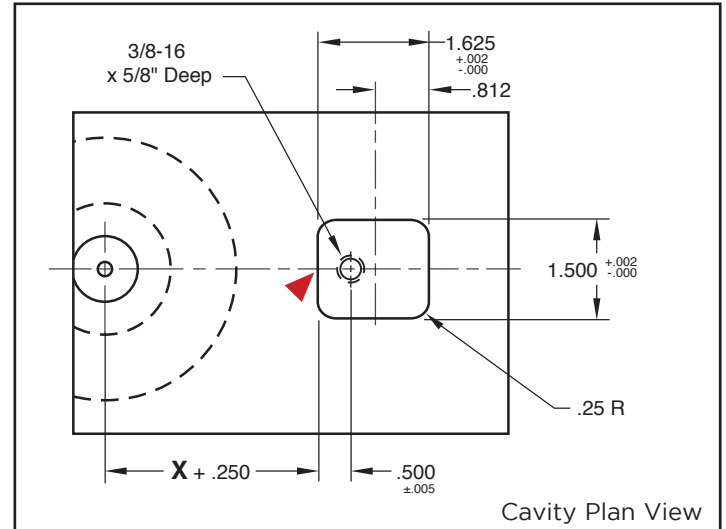
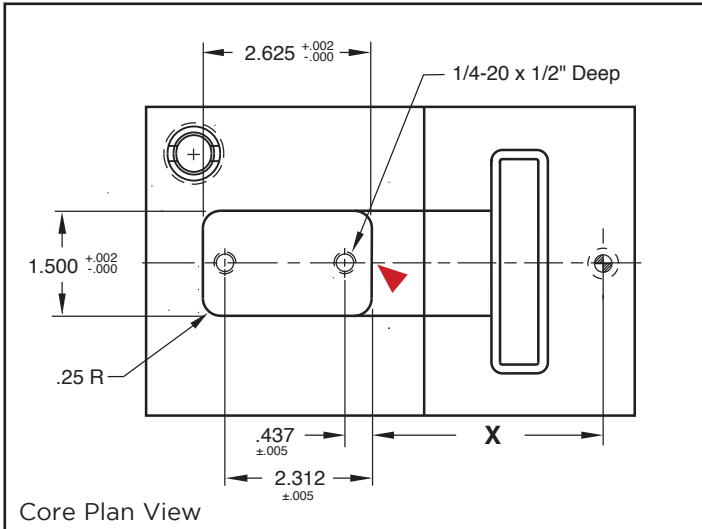
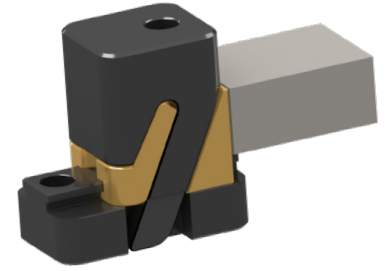


CAM ACTION®

350 SERIES: INCH STANDARD

APPLICATION GUIDELINES

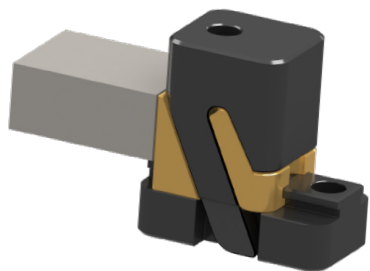
- Travel = .750"
- Each assembly includes SRT-10 Slide Retainer and (3) mounting screws. Individual replacement parts are available.
- Max operating temperature 425°F (220°C).
- Core Pins and Inserts are sold separately on page G-12.



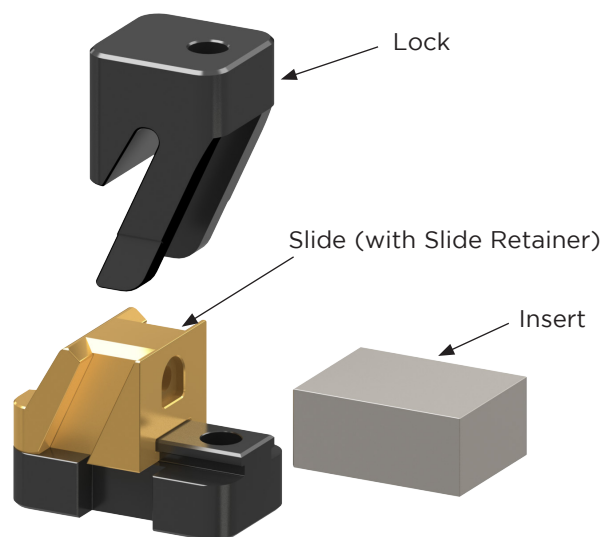
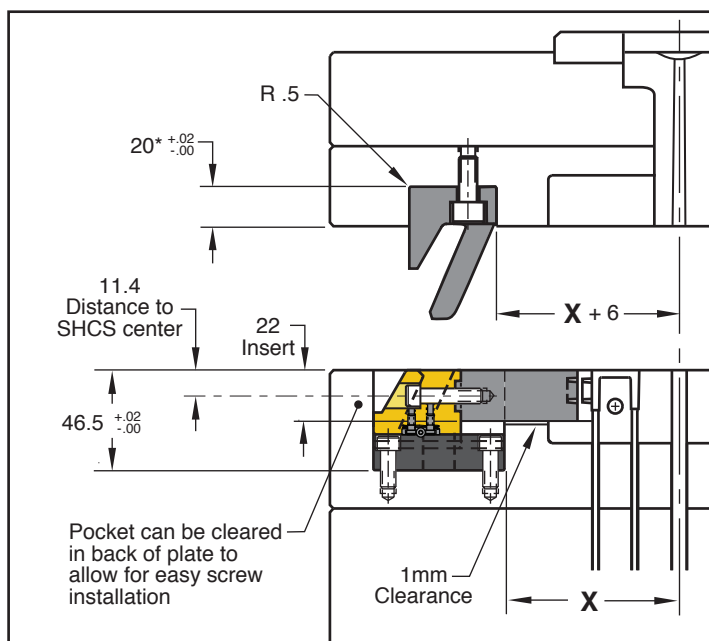
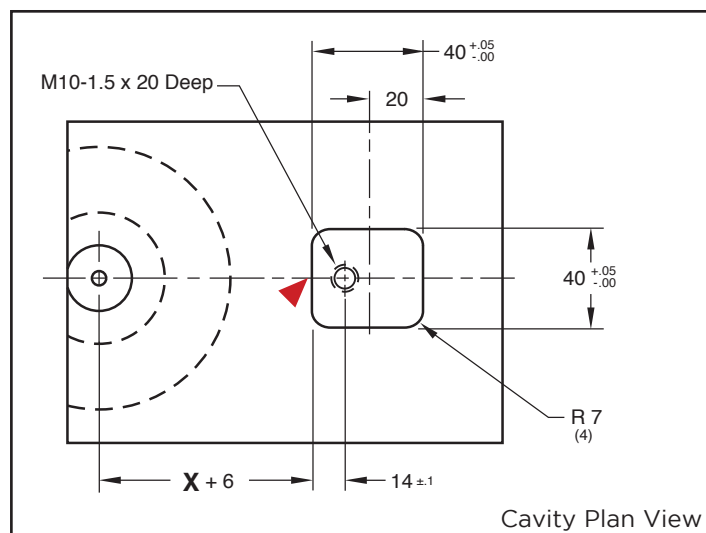
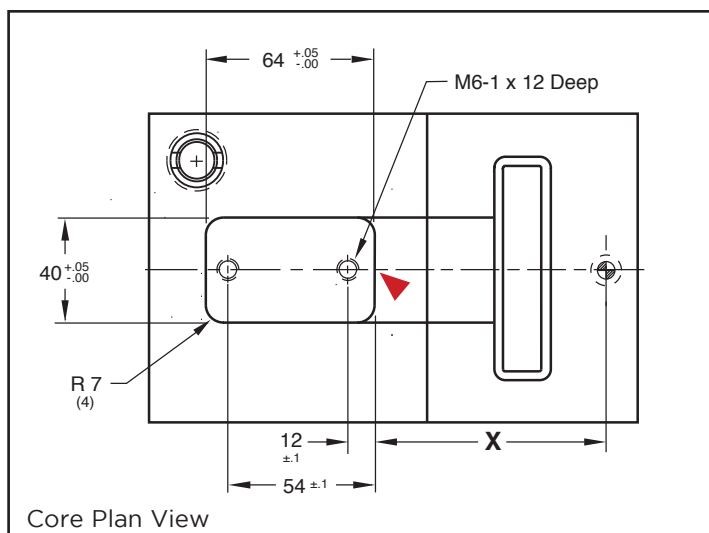
▶ CAD insertion point

PART NAME	MATERIAL/TREATMENT
Lock	H-13, 40-44 HRC, Black Nitride
Slide	H-13, 40-44 HRC, Titanium Nitride
Guide	4140, 28-32 HRC, Black Nitride

CATALOG NUMBER	DESCRIPTION
CA-350	CamAction Unit: 350 Series

CAM ACTION®**350 SERIES: METRIC STANDARD****APPLICATION GUIDELINES**

- Travel = 18mm
- Each assembly includes SRTM-04 Slide Retainer and (3) mounting screws.
- Max operating temperature 425°F (220°C).
- Core Pins and Inserts are sold separately on page G-12.



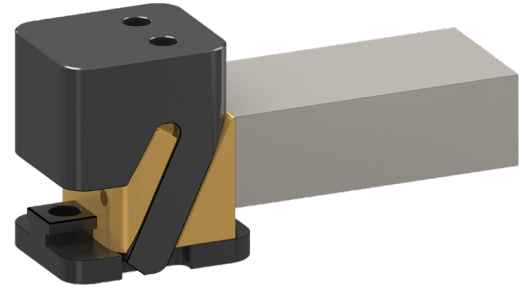
▶ CAD insertion point

PART NAME	MATERIAL/TREATMENT
Lock	H-13, 40-44 HRC, Black Nitride
Slide	H-13, 40-44 HRC, Titanium Nitride
Guide	4140, 28-32 HRC, Black Nitride

CATALOG NUMBER	DESCRIPTION
CAMM-350	CamAction Unit: 350 Series (Metric)

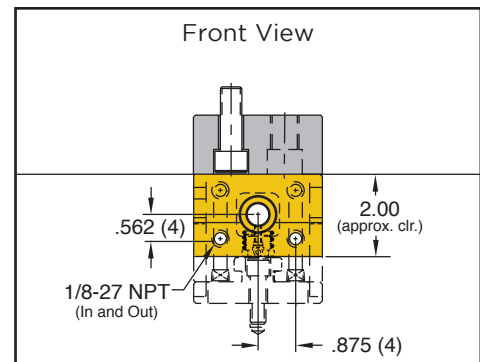
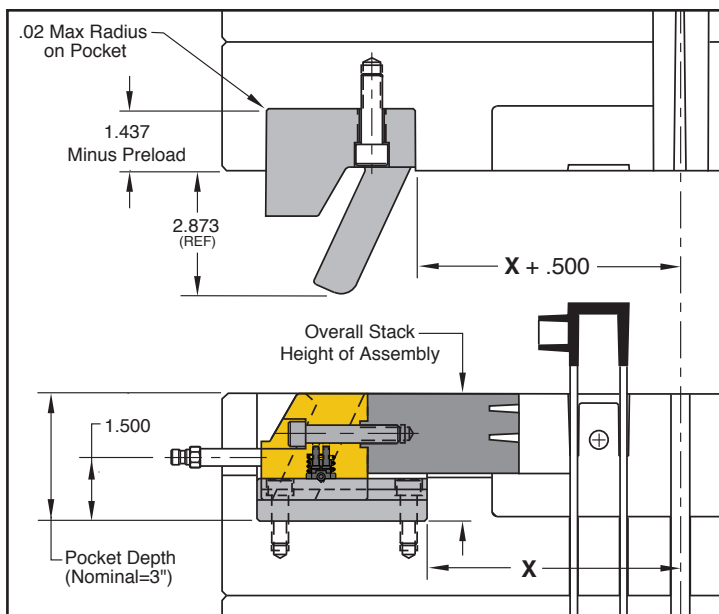
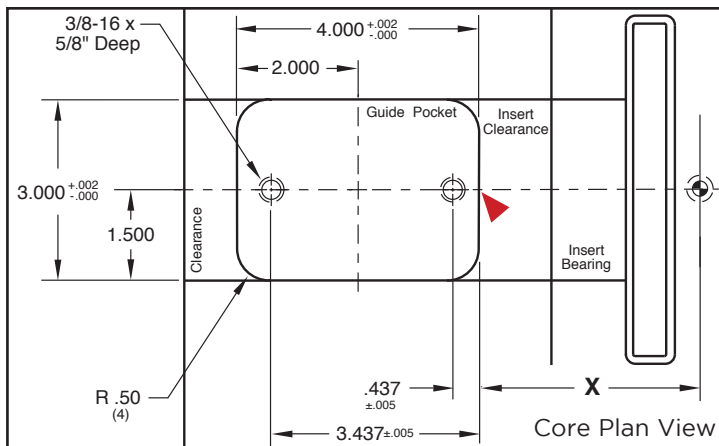
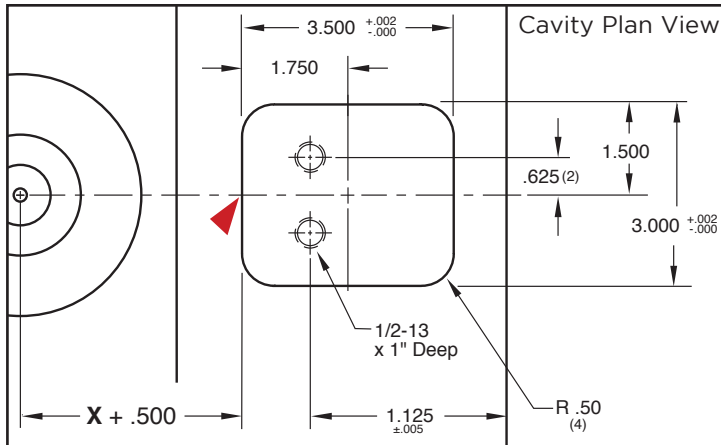


CAM ACTION® 400 SERIES: INCH STANDARD

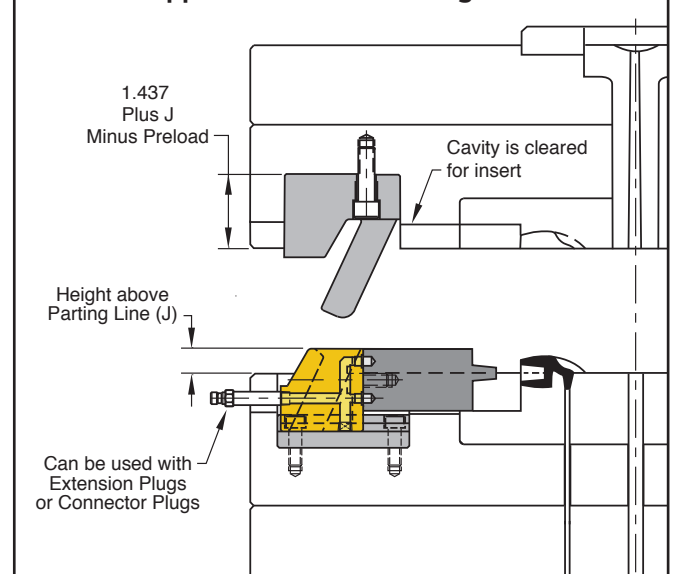


APPLICATION GUIDELINES

- Travel = 1.00"
- Max operating temperature 425°F (220°C).
- Each assembly includes an installed SRT-30 Slide Retainer, Threadless Waterline Plugs (2), O-Rings (2), and (4) mounting screws.
- Inserts are sold separately on page G-13.



Application Above Parting Line



► CAD insertion point

PART NAME	MATERIAL/TREATMENT
Lock	H-13, 40-44 HRC, Black Nitride
Slide	H-13, 40-44 HRC, Titanium Nitride
Guide	4140, 28-32 HRC, Black Nitride

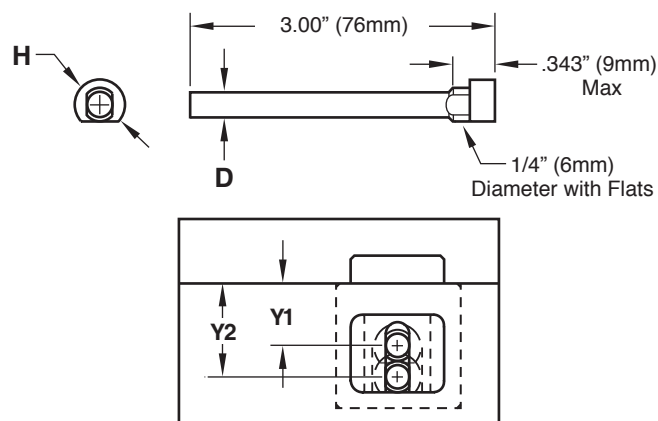
CATALOG NUMBER	DESCRIPTION
CA-400	CamAction Unit with 1" Travel

CAM ACTION ACCESSORIES

100/200 SERIES CORE PINS

**M** M-2 **H** 60-62 HRC **S** Chrome Plated

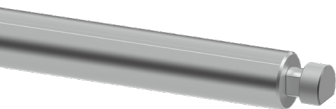
CATALOG NUMBER	D	H	Y1	Y2
CAP1-187	$\frac{.1872}{.1869}$	.37	.500	.750
CAP1-375	$\frac{.3747}{.3744}$	.37	.500	.688
CAPMM-5	$\frac{4.984\text{mm}}{4.992\text{mm}}$	9.5mm	12.7mm	19.05mm
CAPMM-10	$\frac{9.985\text{mm}}{9.992\text{mm}}$	9.5mm	12.7mm	17.40mm



APPLICATION GUIDELINES

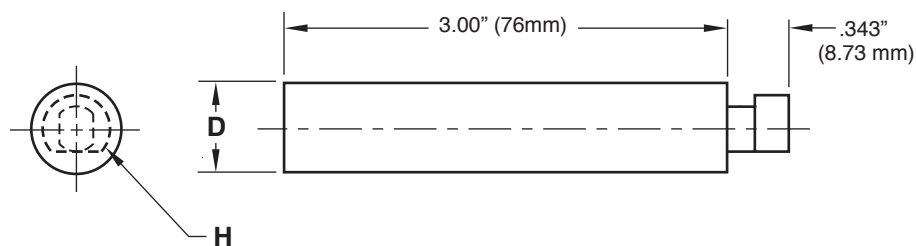
- For use with 100 and 200 Series CamActions.
- When using with the 100 Series, 2° draft per side (minimum) is required in the molding area.
- Core Pin range shown above. Pins are keyed to fit into slot on slide carrier.

200 SERIES CORE PINS

**M** M-2 **H** 60-62 HRC **S** Chrome Plated

CATALOG NUMBER	D	H
CAP2-500	$\frac{.5001}{.5003}$	.37
CAP2MM-13	$\frac{13.002\text{mm}}{13.007\text{mm}}$	9.5mm

For use with 200 Series CamActions only.

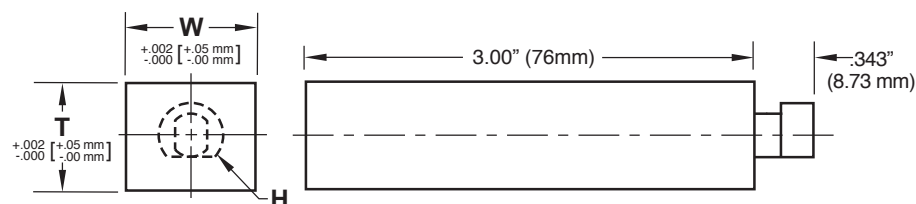


200 SERIES INSERTS

**M** P-20 Pre-Hard **S** Black Nitride

CATALOG NUMBER	T	W	H
CSE2-62X75	.625	.750	.37
CSE2MM-16X19	15.98mm	19mm	9.5mm

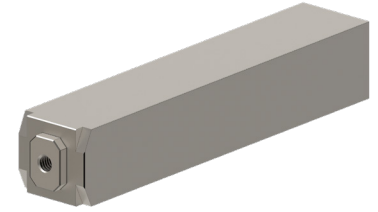
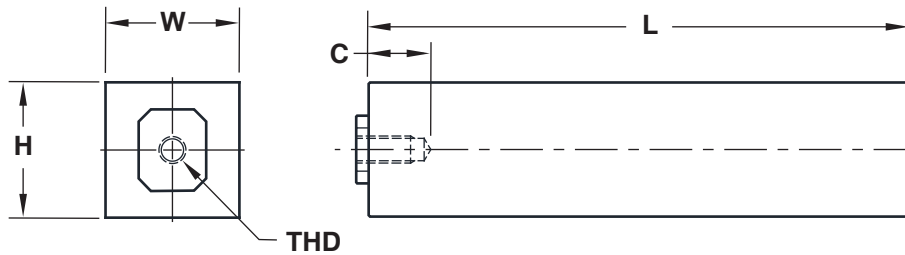
For use with 200 Series CamActions only.





CAM ACTION ACCESSORIES

250 SERIES INSERTS



M DC53 / 1.2360 **H** 58-62 HRC
M H-13 / 1.2343 **H** 48-52 HRC

Inch Standard

ASSEMBLY CATALOG NUMBER	DC53 / 1.2360 CATALOG NUMBER	H-13 / 1.2343 CATALOG NUMBER	W +.000 -.001	H +.000 -.001	L	C	THD
CA-250-15	CSE25P-15L2	CSE25H-15L2	.500	.374	2.250	3/8	#4-40 x 1/2
CA-250-31	CSE25P-31L2.5	CSE25H-31L2.5	.800	.749	2.500	1/2	#8-32 x 7/8
CA-250-50	CSE25P-50L4	CSE25H-50L4	1.250	1.249	4.000	3/4	1/4-20 x 1-1/4

Socket Head Cap Screw included.

M DC53 / 1.2360 **H** 58-62 HRC
M H-13 / 1.2343 **H** 48-52 HRC

Metric Standard

ASSEMBLY CATALOG NUMBER	DC53 / 1.2360 CATALOG NUMBER	H-13 / 1.2343 CATALOG NUMBER	W +.00 -.03	H +.00 -.03	L	C	THD
CAMM-250-4	CSE25MMP-4L60	CSE25MMH-4L60	12	10	60	8	M3 -.5 x 12
CAMM-250-8	CSE25MMP-8L80	CSE25MMH-8L80	20	20	80	11	M4 -.7 x 22
CAMM-250-12	CSE25MMP-12L100	CSE25MMH-12L100	32	29	100	15	M5-.8 x 30

Socket Head Cap Screw included.



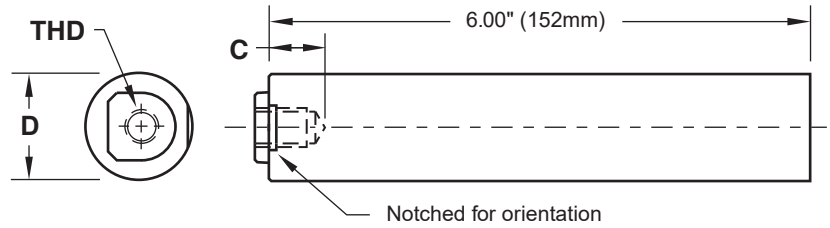
CAM ACTION ACCESSORIES

300/350 SERIES CORE PINS

M M-2 **H** 58-62 HRC **S** Chrome Plated

CATALOG NUMBER	D	THD	C
CAP3-750	$\frac{.7504}{.7508}$	1/4-20 x 7/8	3/4
CAP3MM-19	$\frac{19.009\text{mm}}{19.019\text{mm}}$	M6-1 x 20	20mm

Socket Head Cap Screw included.

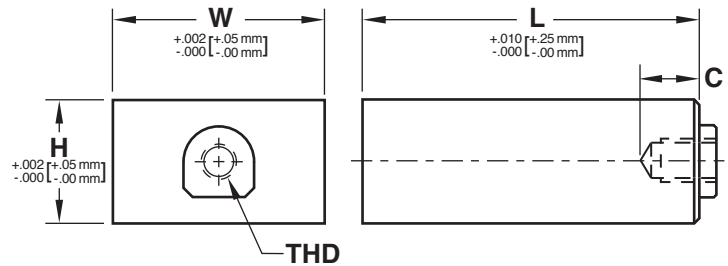


300 SERIES INSERTS

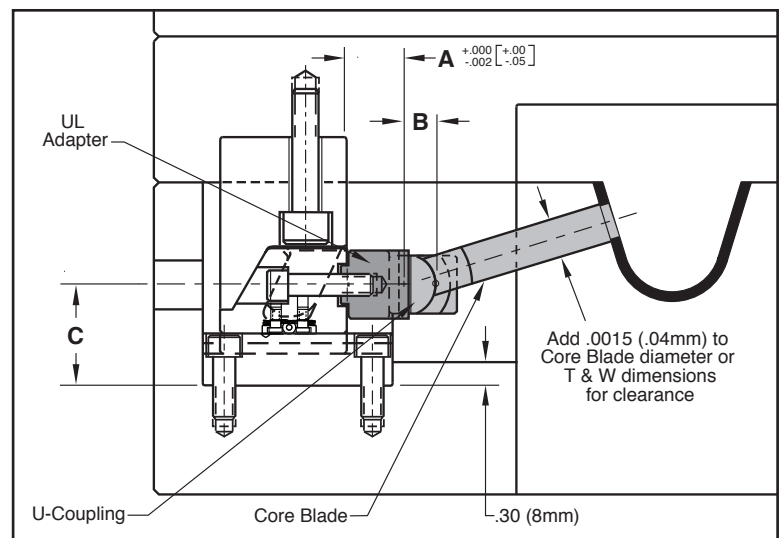
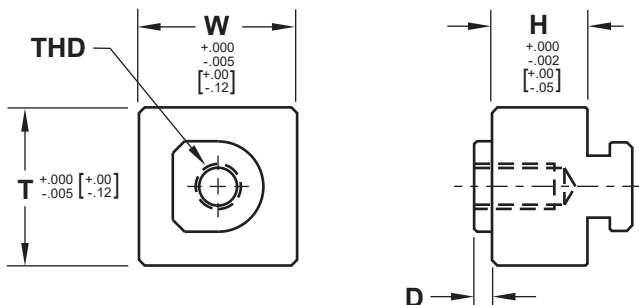
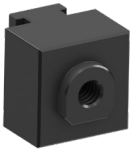
**M** P-20 Pre-Hard **S** Salt Bath Nitride

CATALOG NUMBER	H	W	L	THD	C
CSE3-50	.875	1.500	.50	1/4-20 x 7/8	5/8
CSE3-200	.875	1.500	2.00	1/4-20 x 7/8	5/8
CSE3MM-12	22mm	38mm	12mm	M6-1 x 20	15mm
CSE3MM-50	22mm	38mm	50mm	M6-1 x 20	15mm

Socket Head Cap Screw included.



300 SERIES UL ADAPTERS

**M** 4140 **S** Salt Bath Nitride

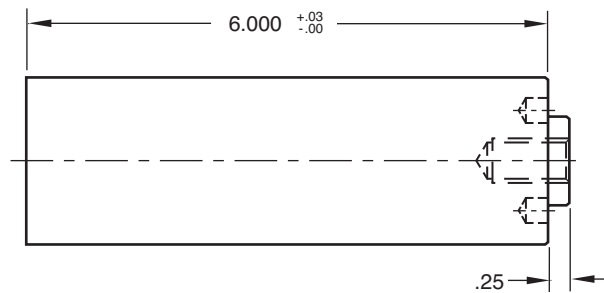
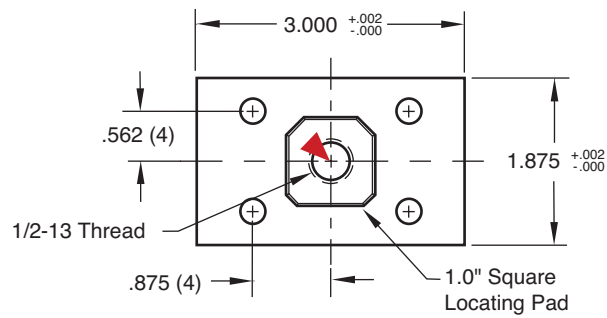
CATALOG NUMBER	T	W	H	D	THD	A	B	C	COMPATIBLE U-COUPLING
CTG-300	.875	.875	.563	.098	1/4-20 x 7/8	.75	.406	1.187	UCU87
CTGMM-300	23mm	23mm	6mm	2.5mm	M6-1 x 22	12mm	10mm	30.15mm	UCMM22

Socket Head Cap Screw included. UniLifter Core Blades and U-Couplings are sold in section H.



CAM ACTION ACCESSORIES

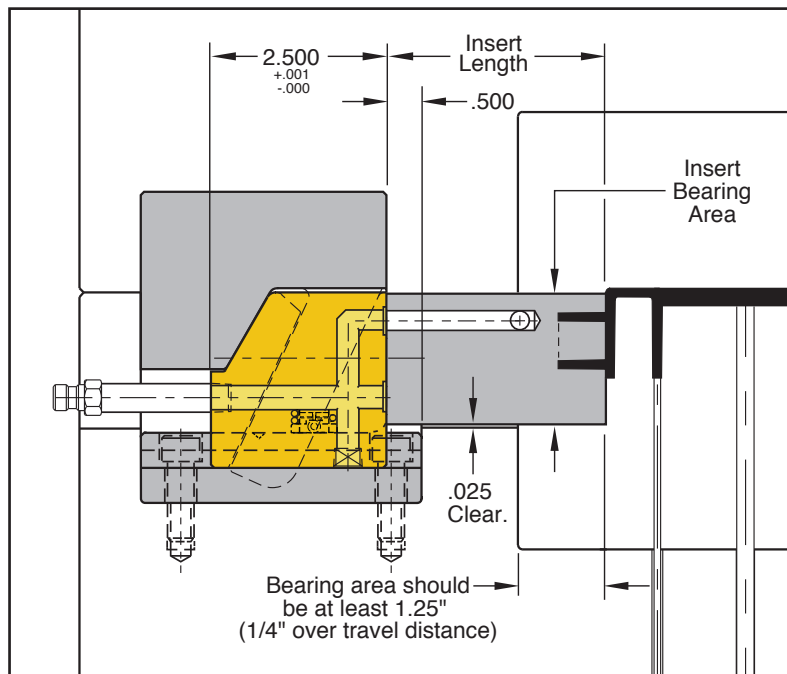
400 SERIES INSERTS



M P-20 Pre-Hard **S** Salt Bath Nitride

CATALOG NUMBER	DESCRIPTION
CSE4-18X30	CA-400 Insert

1/2-13 x 1-3/4 Socket Head Cap Screw included.



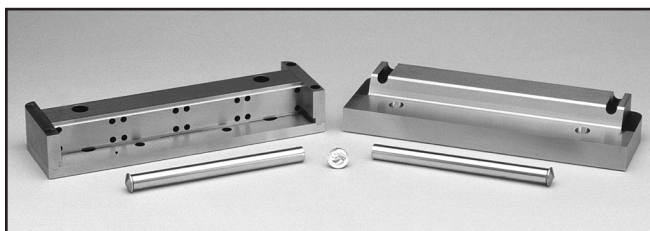
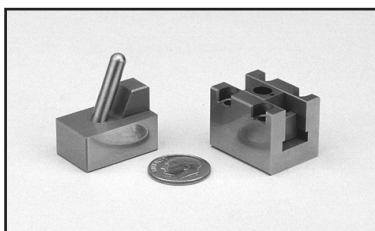
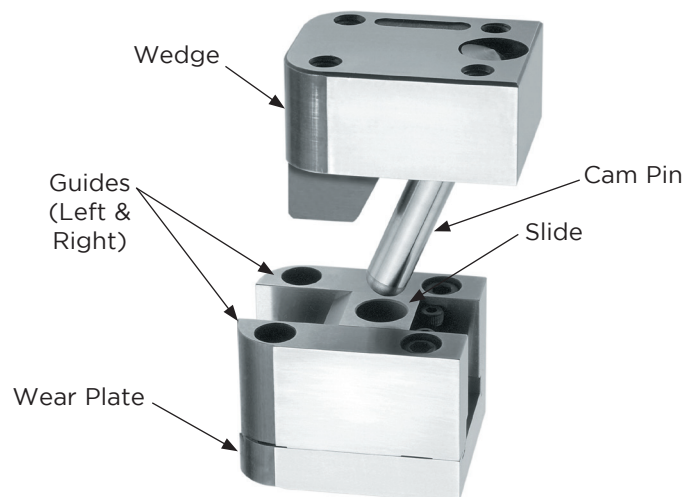
▶ CAD insertion point

VERSA-SLIDE® SELECTION GUIDE

Progressive's Versa-Slide assemblies, a product line acquired from Omni Mold Systems®, offer a range of pre-engineered, off-the-shelf side actions.

- Wide range of sizes and travels.
- Slide Faces are available for all assemblies, sold separately.
- For application assistance, please contact tech@procomps.com.

PART NAME	MATERIAL
Slide	H-13, 48-50 HRC
Wedge	S-7, 54-56 HRC
Guide Shoe (10 Series) Guides	S-7, 54-56 HRC
Wear Plate	S-7, 54-56 HRC
Cam Pin: CP-10-A Cam Pin: CP-20 & CP-30	H-13, 50-52 HRC H-13, Nitrided to 65-70 HRC



CAM TRAVEL RANGE	OVERALL WIDTH (WT) INCLUDING GRIND STOCK	SLIDE WIDTH (SW)	SLIDE HEIGHT (SH)	VERSA-SLIDE SERIES	PAGE NUMBER
.250	.760 - 1.760	.320-1.320	.500	10 Series	G-15
.500 - .600	1.510	.625	.460 - 1.460	20 Series	G-16
.500 - 1.800	2.260	1.375	.640 - 1.640	25 Series	G-17
.500 - 1.800	2.948	2.063	.640 - 1.640	30 Series	G-17
.500 - 1.800	4.073	3.188	.640 - 1.640	40 Series	G-18
.500 - 1.800	5.255	4.375	.640 - 1.640	45 Series	G-19
.500 - 1.800	6.510	5.624	.640 - 1.640	50 Series	G-20 & G-21
.500 - 1.800	8.005	7.124	.640 - 1.640	55 Series	G-20 & G-21
.500 - 1.800	9.635	8.749	.640 - 1.640	60 Series	G-20 & G-21

APPLICATION GUIDELINES

- Select the Versa-Slide based on the detail width and the required travel.
- Refer to individual pages for detailed specifications.
- Slide Faces are sold separately on page G-22.
- Machining instructions can be found on page G-23.



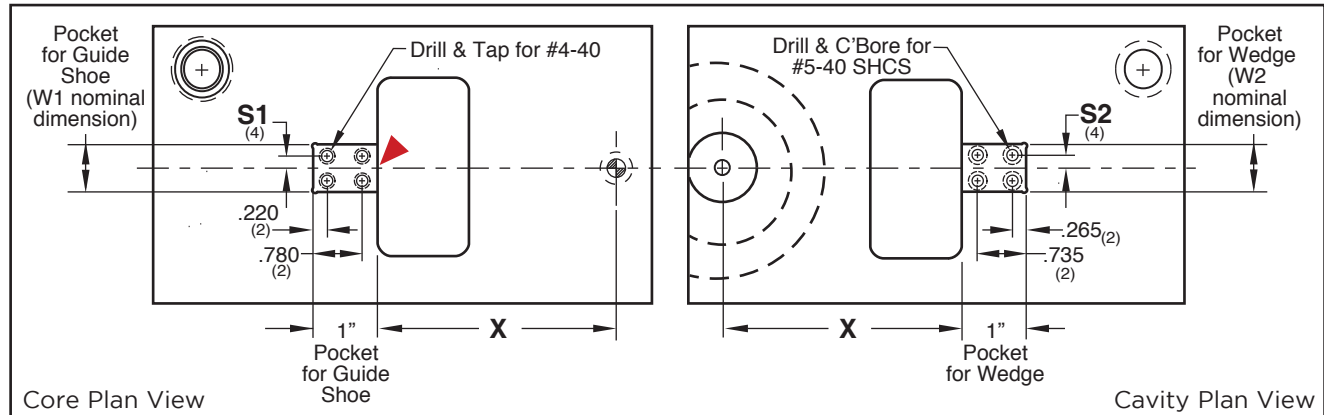
VERSA-SLIDE 10 SERIES

APPLICATION GUIDELINES

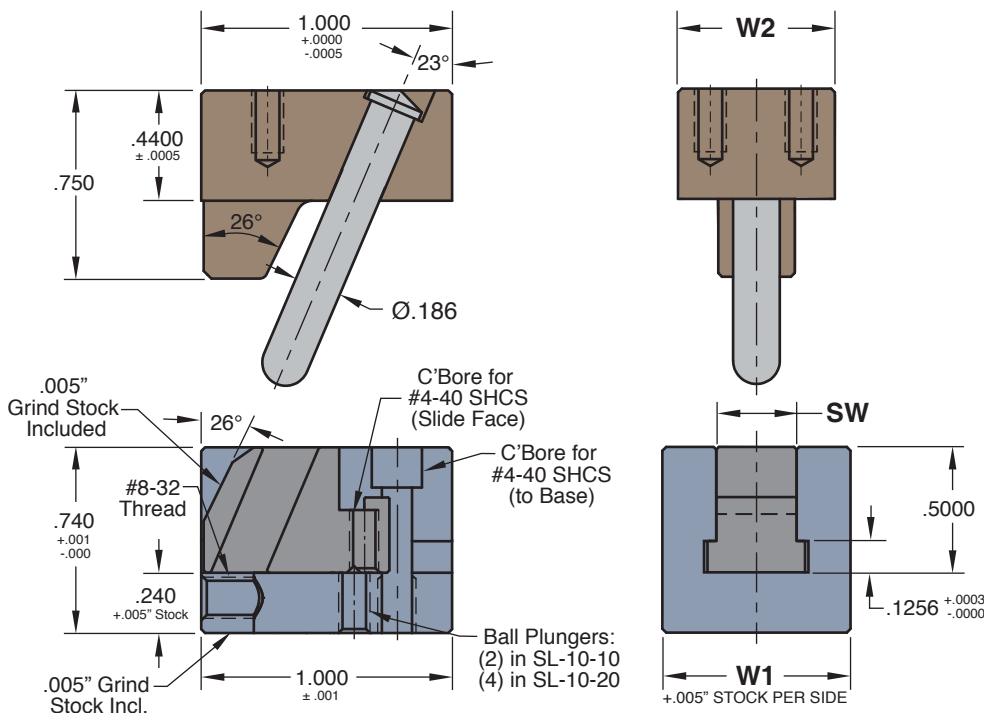
- Travel = .250"
- Slide Faces are sold separately on page G-23.
- Machine pockets from the common location "X" to the dimensions shown in the chart and graphics below.
- High temperature assemblies include Ball Plungers capable of reaching 600°F (315°C). Specify "-HT" at the end of the catalog number.



► CAD insertion point



Versa-Slide Part Dimensions



Assemblies include:

- All machined components with grind stock as noted.
- Ball Plungers (2 or 4)
- CP-10-A (1) Cam Pin, finished.
- Screws are included:
 - #4-40 SHCS (4) installed in the Guide Shoe through to the mold base.
 - #4-40 (1 or 2) SHCS for attachment of the Slide Face or manufactured slides.
 - #8-32 LHCS (1) for an optional positive slide stop in the back of the Wear Plate.

CATALOG NUMBER	SW $\pm .0000$ $-.0003$	W1 $\pm .005/S$ GRIND STOCK	W2 $\pm .000$ $-.002$	S1 $\pm .01$	S2 $\pm .01$
SL-10-10	.320	.750	.625	.280	.205
SL-10-20	1.320	1.750	1.750	.780	.768

VERSA-SLIDE

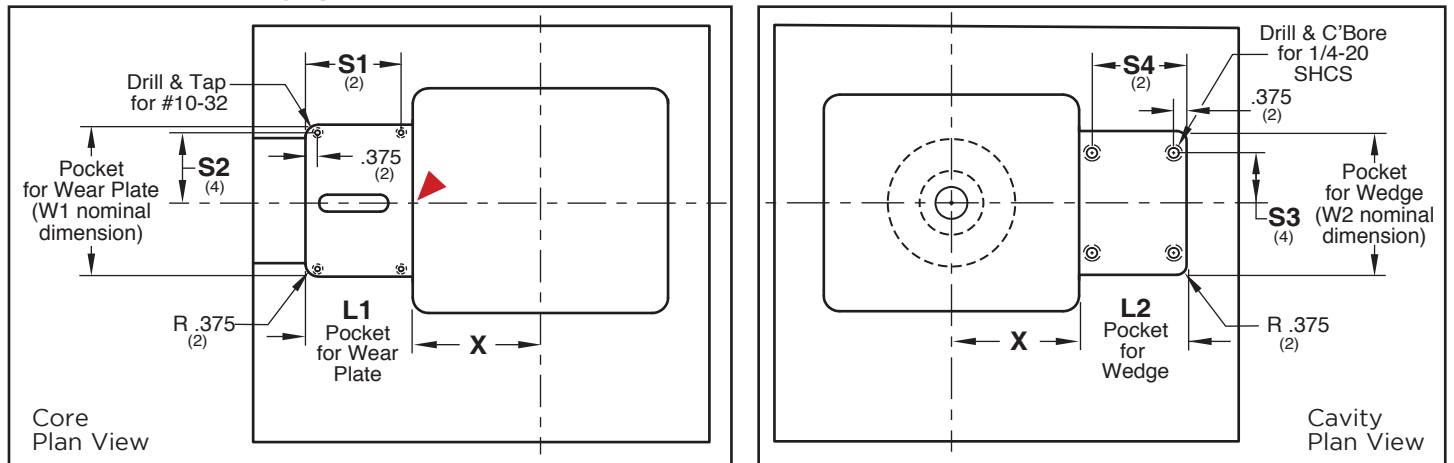
20 SERIES



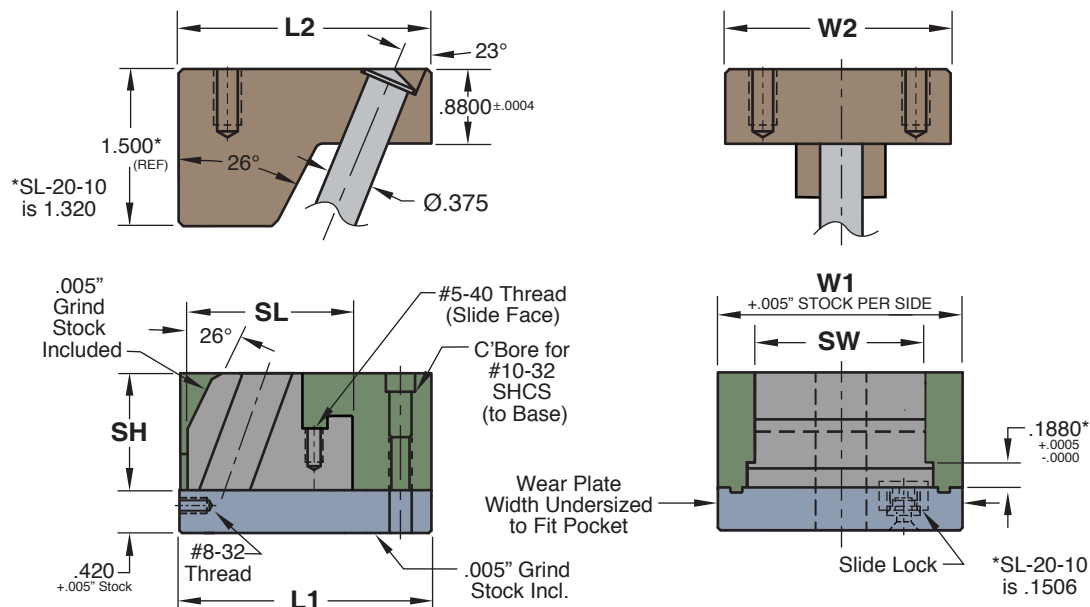
APPLICATION GUIDELINES

- Slide Faces are sold separately on page G-23.
- Machine pockets from the common location "X" to the dimensions shown in the chart and graphics below.
- High temperature assemblies include Slide Lock springs capable of reaching 600°F (315°C). Specify "-HT" at the end of the catalog number.
- See page G-23 for additional machining details and for Mold-Ready Cam Pins.

Pocket and Machining Specifications



Versa-Slide Part Dimensions



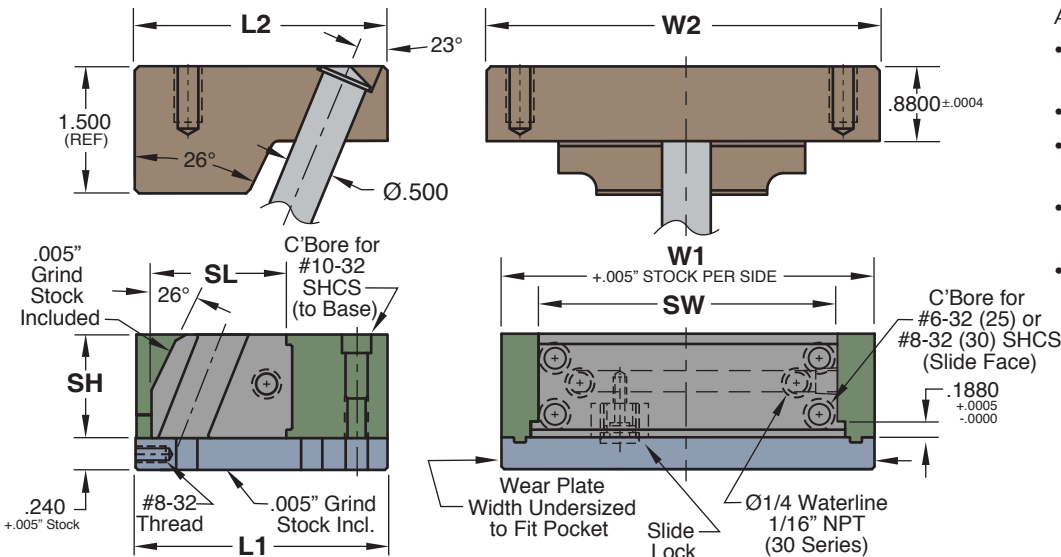
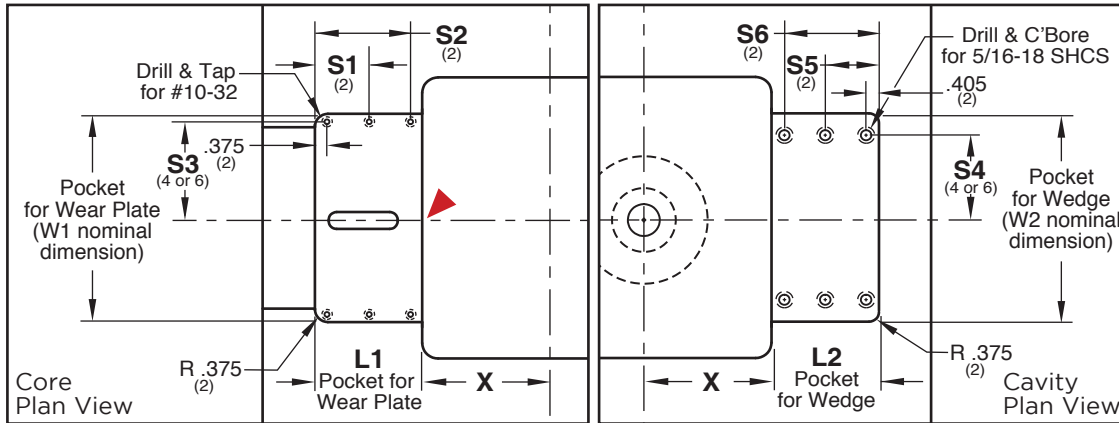
Assemblies include:

- All machined components with grind stock as noted.
- SLK-8A (1) Slide Lock.
- CP-20 Cam Pin (1), unfinished length.
- Screws are included:
 - #10-32 SHCS (4) installed in the Guides through the Wear Plate to the mold base.
 - #5-40 SHCS (2) for attachment of the Slide Face or manufactured slides.
 - #4-40 FHCS (1) for Slide Lock attachment.
 - #8-32 LHCS (1) for an optional positive slide stop in the back of the Wear Plate.

CATALOG NUMBER	TRAVEL	SH ±.0005	SW +.0000 -.0005	W1 +.005/S GRIND STOCK	W2 +.000 -.004	SL	L1 ±.002	L2 +.0000 -.0005	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01
SL-20-10	.500	.460	.625	1.500	1.500	1.490	1.990	2.000	1.625	.531	.500	1.625
SL-20-20	.600	.960				1.390						
SL-20-30	.600	1.460										



VERSA-SLIDE **25-30 SERIES**



Assemblies include:

- All machined components with grind stock as noted.
- SLK-8A (1) Slide Lock.
- CP-30 Cam Pin (1), unfinished length.
- BR06 Pipe Plug (1) for assemblies with cooling.
- Screws are included with quantity varying per size:
 - #10-32 SHCS installed in the Guides through the Wear Plate to the mold base.
 - #6-32 or #8-32 (30) SHCS (Slide Face)
 - #6-32 or #8-32 SHCS for attachment of the Slide Face or manufactured slides.
 - #8-32 LHCS for an optional positive slide stop in the back of the Wear Plate.

► CAD insertion point

CATALOG NUMBER	TRAVEL	SH ±.0005	SW +.0000 -.0005	W1 +.005/S GRIND STOCK	W2 +.000 -.004	SL	L1 ±.002	L2 +.0000 -.0005	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	S5 ±.01	S6 ±.01
SL-25-10	.800	.640	1.375	2.250	2.249	1.560	2.360	2.370	—	1.995	.921	.730	—	1.965
SL-25-20	1.300						2.860	2.870	—	2.495			—	2.465
SL-25-30	1.800						3.360	3.370	1.685	2.995			1.685	2.965
SL-25-40	.700	1.140				1.660	2.360	2.370	—	1.995			—	1.965
SL-25-50	1.200						2.860	2.870	—	2.495			—	2.465
SL-25-60	1.700						3.360	3.370	1.685	2.995			1.685	2.965
SL-25-70	.500	1.640				1.860	2.360	2.370	—	1.995			—	1.965
SL-25-80	1.000						2.860	2.870	—	2.495			—	2.465
SL-25-90	1.500						3.360	3.370	1.685	2.995			1.685	2.965
SL-30-10	.800	.640	2.063	2.938	2.937	1.560	2.360	2.370	—	1.995	1.265	.800	—	1.965
SL-30-20	1.300						2.860	2.870	—	2.495			—	2.465
SL-30-30	1.800						3.360	3.370	1.685	2.995			1.685	2.965
SL-30-40	.700	1.140				1.660	2.360	2.370	—	1.995			—	1.965
SL-30-50	1.200						2.860	2.870	—	2.495			—	2.465
SL-30-60	1.700						3.360	3.370	1.685	2.995			1.685	2.965
SL-30-70	.500	1.640				1.860	2.360	2.370	—	1.995			—	1.965
SL-30-80	1.000						2.860	2.870	—	2.495			—	2.465
SL-30-90	1.500						3.360	3.370	1.685	2.995			1.685	2.965

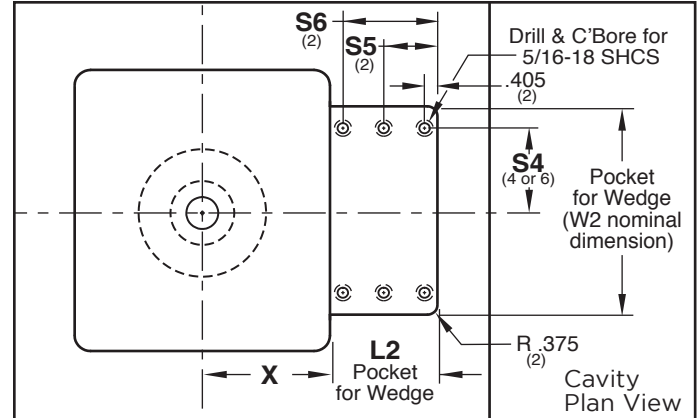
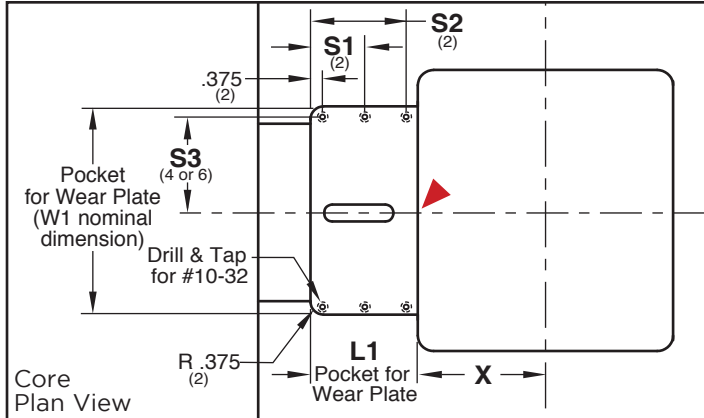
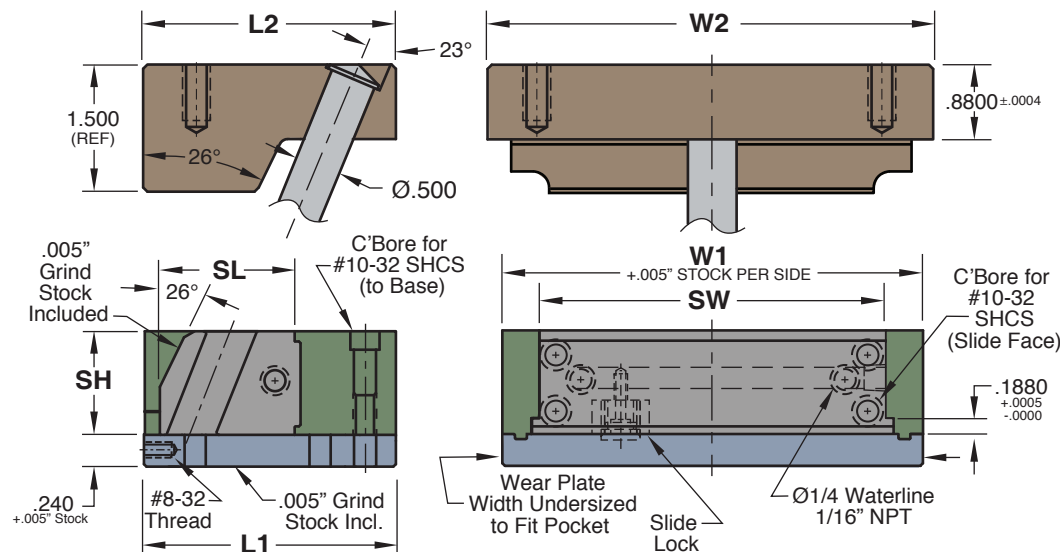
Cooling lines available on the 30 series on sizes with the suffixes of -40, -50, -60, -70, -80, and -90.

VERSA-SLIDE**40 SERIES****APPLICATION GUIDELINES**

- Machine pockets from the common location "X" to the dimensions shown in the chart and graphics below.
- High temperature assemblies include Slide Lock springs capable of reaching 600°F (315°C). Specify "-HT" at the end of the catalog number.
- Cooling channels are included on larger assemblies.
- Slide Faces are sold separately on page G-22.
- See page G-23 for additional machining details and for Mold-Ready Cam Pins.

Pocket and Machining Specifications

▶ CAD insertion point

**Versa-Slide Part Dimensions**

Assemblies include:

- All machined components with grind stock as noted.
- SLK-8A (1) Slide Lock.
- BR06 (1) Brass Pipe Plugs for assemblies with cooling lines. -40 through -90.
- CP-30 Cam Pin (1), unfinished length.
- Screws are included with quantity varying per size:
 - #10-32 SHCS installed in the Guides through the Wear Plate to the mold base.
 - #10-32 SHCS for the Slide Face or manufactured slides.
 - #8-32 LHCS for an optional positive slide stop.

CATALOG NUMBER	TRAVEL	SH ±.0005	SW +.0000 -.0005	W1 +.005/S GRIND STOCK	W2 +.000 -.004	SL	L1 ±.002	L2 +.0000 -.0005	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	S5 ±.01	S6 ±.01
SL-40-10	.800	.640	3.188	4.063	4.062	1.560	2.360	2.370	—	1.995	1.828	1.360	—	1.965
SL-40-20	1.300						2.860	2.870	—	2.495			—	2.465
SL-40-30	1.800						3.360	3.370	1.685	2.995			1.685	2.965
SL-40-40	.700	1.140				1.660	2.360	2.370	—	1.995			—	1.965
SL-40-50	1.200						2.860	2.870	—	2.495			—	2.465
SL-40-60	1.700						3.360	3.370	1.685	2.995			1.685	2.965
SL-40-70	.500	1.640				1.860	2.360	2.370	—	1.995			—	1.965
SL-40-80	1.000						2.860	2.870	—	2.495			—	2.465
SL-40-90	1.500						3.360	3.370	1.685	2.995			1.685	2.965

Cooling lines included on sizes with the suffixes of -40, -50, -60, -70, -80, and -90.



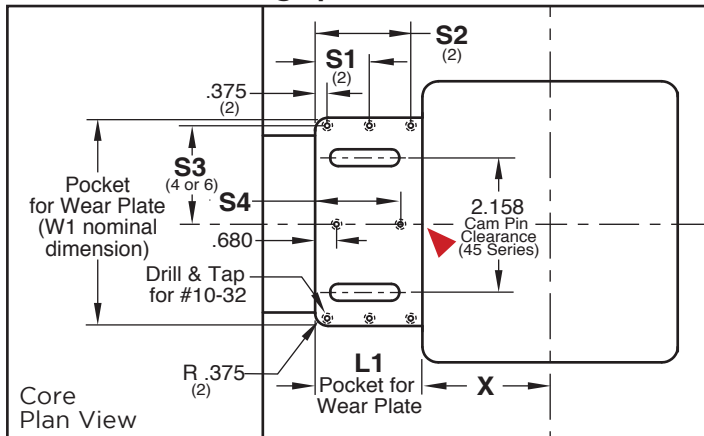
VERSA-SLIDE 45 SERIES



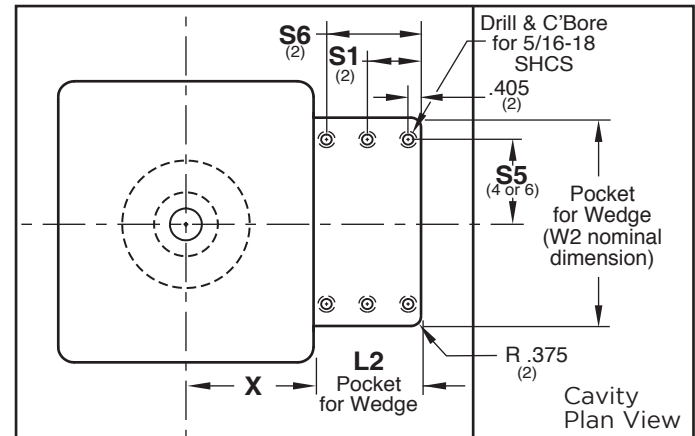
APPLICATION GUIDELINES

- Machine pockets from the common location "X" to the dimensions shown in the chart and graphics below.
- High temperature assemblies include Slide Lock springs capable of reaching 600°F (315°C). Specify "-HT" at the end of the catalog number.
- Cooling channels are included on larger assemblies.
- Slide Faces are sold separately on page G-22.
- See page G-23 for additional machining details and for Mold-Ready Cam Pins.

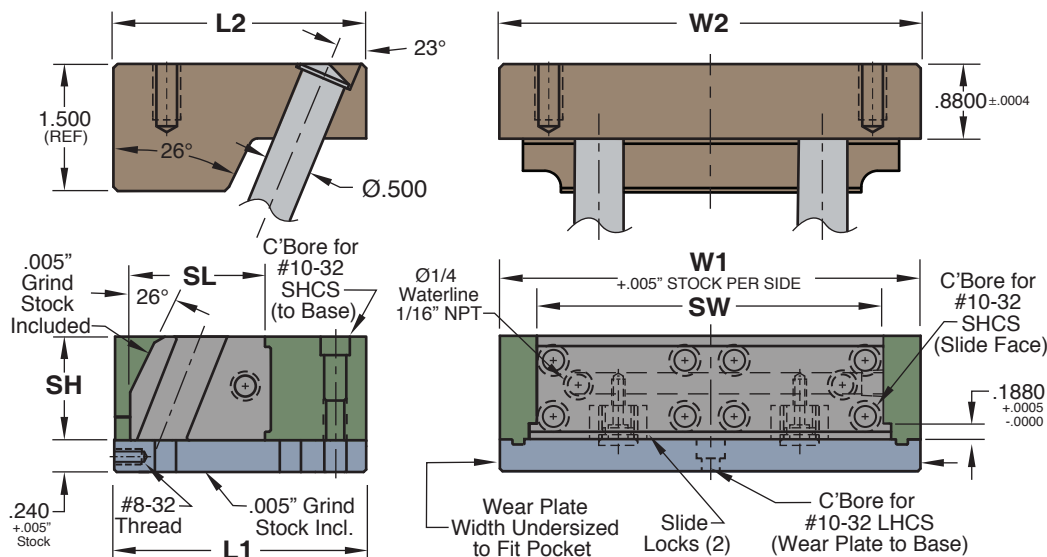
Pocket and Machining Specifications



CAD insertion point



Versa-Slide Part Dimensions



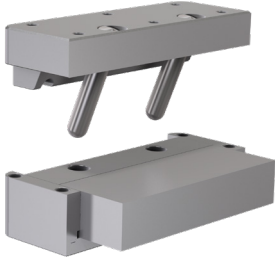
Assemblies include:

- All machined components with grind stock as noted.
- SLK-8A (2) Slide Locks.
- BR06 Brass Pipe Plug (1) for assemblies with cooling lines, -40 through -90.
- CP-30 Cam Pins (2), unfinished length.
- Screws are included with quantity varying per size:
 - #10-32 SHCS installed in the Guides through the Wear Plate to the mold base.
 - #10-32 SHCS for the Slide Face or manufactured slides.
 - #10-32 LHCS (2) for Wear Plate to base.
 - #8-32 LHCS for an optional positive slide stop.

CATALOG NUMBER	TRAVEL	SH ±.0005	SW +.0000 -.0005	W1 +.005/S GRIND STOCK	W2 +.000 -.004	SL	L1 ±.002	L2 +.0000 -.0005	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	S5 ±.01	S6 ±.01
SL-45-10	.800	.640	4.375	5.245	5.249	1.560	2.360	2.370	—	1.995	2.421	1.680	1.954	1.965
SL-45-20	1.300						2.860	2.870	—	2.495		2.180		2.465
SL-45-30	1.800						3.360	3.370	1.685	2.995		2.680		2.965
SL-45-40	.700	1.140				1.660	2.360	2.370	—	1.995		1.680		1.965
SL-45-50	1.200						2.860	2.870	—	2.495		2.180		2.465
SL-45-60	1.700						3.360	3.370	1.685	2.995		2.680		2.965
SL-45-70	.500	1.640				1.860	2.360	2.370	—	1.995		1.680		1.965
SL-45-80	1.000						2.860	2.870	—	2.495		2.180		2.465
SL-45-90	1.500						3.360	3.370	1.685	2.995		2.680		2.965

Cooling lines included on sizes with the suffixes of -40, -50, -60, -70, -80, and -90.

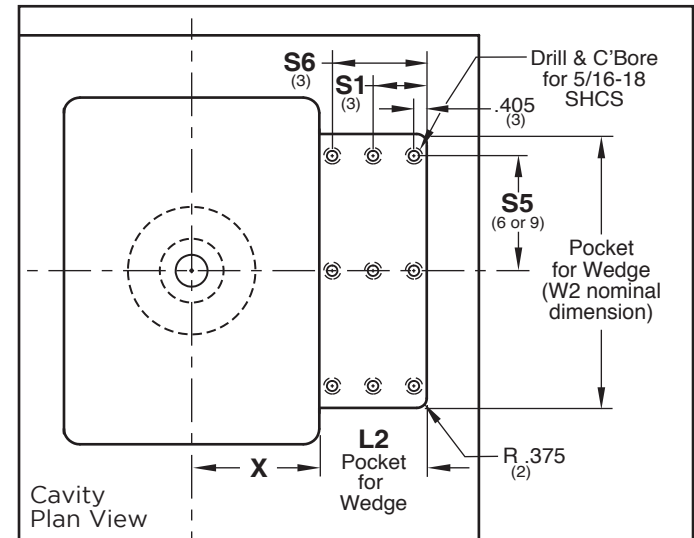
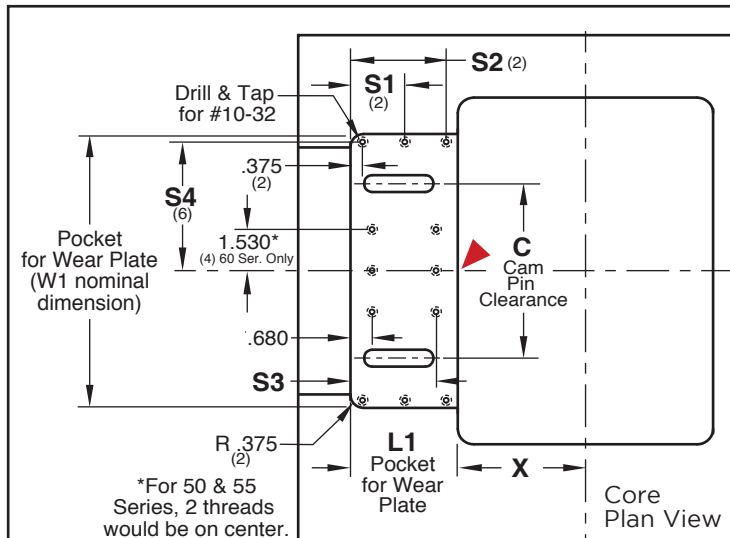
VERSA-SLIDE 50-55-60 SERIES



APPLICATION GUIDELINES

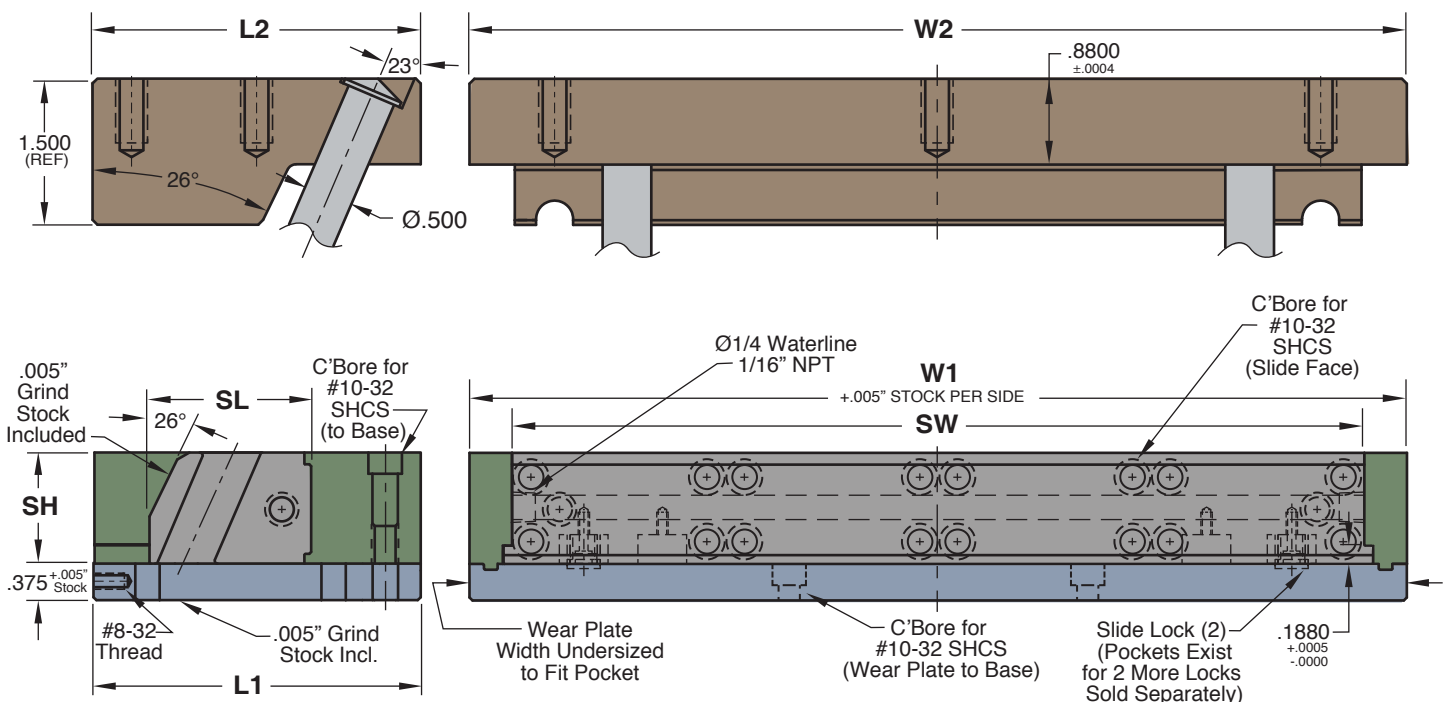
- Machine pockets from the common location "X" to the dimensions shown in the chart and graphics below.
- High temperature assemblies include Slide Lock springs capable of reaching 600°F (315°C). Specify "-HT" at the end of the catalog number.
- Cooling channels are included on larger assemblies.
- Slide Faces are sold separately on page G-22.
- See page G-23 for additional machining details and for Mold-Ready Cam Pins.

Pocket and Machining Specifications



► CAD insertion point

Versa-Slide Part Dimensions





VERSA-SLIDE 50-55-60 SERIES

Assemblies include:

- All machined components with grind stock as noted on the opposite page.
- SLK-8A Slide Locks (2).
- BR06 Brass Pipe Plugs (2) for assemblies with cooling lines.
- CP-30 Cam Pins (2), unfinished length.
- Screws are included with quantity varying per size:
 - #10-32 SHCS installed in the Guides through the Wear Plate to the mold base.
 - #10-32 SHCS installed on the Wear Plate to the mold base.
 - #10-32 SHCS for attachment of the Slide Face or manufactured slides.
 - #8-32 LHCS for an optional positive slide stop in the back of the Wear Plate.

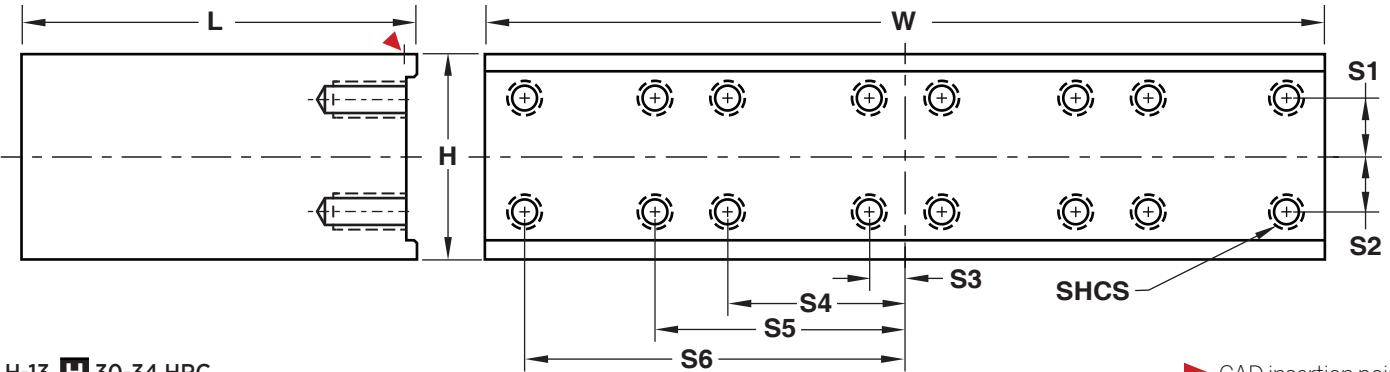


CATALOG NUMBER	TRAVEL	SH ±.0005	SW +.0000 -.0005	W1 +.005 /SIDE GRIND STOCK	W2 +.000 -.004	SL	L1 ±.002	L2 +.0000 -.0005	C	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	S5 ±.01	S6 ±.01
SL-50-10	.800	.640	5.624	6.500	6.499	1.560	2.360	2.370	2.812	—	1.995	1.680	3.046	2.550	1.965
SL-50-20	1.300					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-50-30	1.800					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-50-40	.700	1.140				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-50-50	1.200					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-50-60	1.700					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-50-70	.500	1.640				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-50-80	1.000					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-50-90	1.500					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-55-10	.800	.640	7.124	7.995	7.999	1.560	2.360	2.370	4.312	—	1.995	1.680	3.790	3.300	1.965
SL-55-20	1.300					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-55-30	1.800					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-55-40	.700	1.140				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-55-50	1.200					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-55-60	1.700					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-55-70	.500	1.640				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-55-80	1.000					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-55-90	1.500					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-60-10	.800	.640	8.749	9.625	9.623	1.560	2.360	2.370	6.390	—	1.995	1.680	4.609	4.100	1.965
SL-60-20	1.300					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-60-30	1.800					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-60-40	.700	1.140				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-60-50	1.200					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-60-60	1.700					1.860	3.360	3.370		1.685	2.995	2.680			2.965
SL-60-70	.500	1.640				1.560	2.360	2.370		—	1.995	1.680			1.965
SL-60-80	1.000					1.660	2.860	2.870		—	2.495	2.180			2.465
SL-60-90	1.500					1.860	3.360	3.370		1.685	2.995	2.680			2.965

Cooling lines included in sizes with the suffixes of -40, -50, -60, -70, -80, and -90.

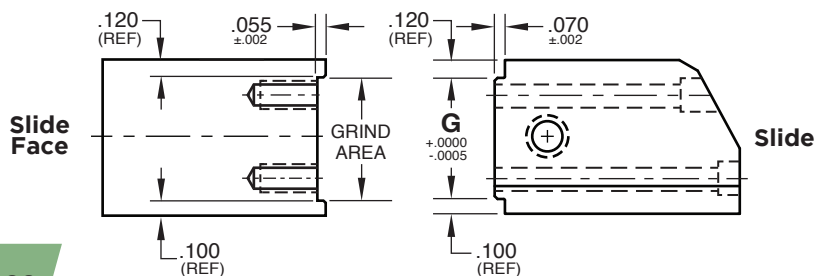
VERSA-SLIDE**SLIDE FACES: 25-60 SERIES****APPLICATION GUIDELINES**

- Provided as soft H-13 for machining of part details, ready for heat treatment, coatings and final fitting within the Versa-Slide assemblies.
- The appropriate quantity of screws for attaching the Slide Face is included with each assembly sold on pages G15-G21.

**M** H-13 **H** 30-34 HRC

▶ CAD insertion point

CATALOG NUMBER	H +.005 /SIDE GRIND STOCK	W +.005 /SIDE GRIND STOCK	L +.005 /SIDE GRIND STOCK	G SLIDE (BELOW)	SHCS	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	S5 ±.01	S6 ±.01	FOR USE WITH SLIDE ASSEMBLY
SLF-25101	.640	1.375	2.050	.420	#6-32	.080	.080	.550	—	—	—	SL-25-10, -20, -30
SLF-25102	1.140			.920		.330	.330		—	—	—	SL-25-40, -50, -60
SLF-25103	1.640			1.420		.580	.580		—	—	—	SL-25-70, -80, -90
SLF-30101	.640	2.063	2.050	.420	#8-32	.020	—	.885	—	—	—	SL-30-10, -20, -30
SLF-30102	1.140			.920		.340	.365		—	—	—	SL-30-40, -50, -60
SLF-30103	1.640			1.420		.590	.615		—	—	—	SL-30-70, -80, -90
SLF-40101	.640	3.188	2.050	.420	#10-32	CENTER	—	1.385	—	—	—	SL-40-10, -20, -30
SLF-40102	1.140			.920		.320	.340		—	—	—	SL-40-40, -50, -60
SLF-40103	1.640			1.420		.570	.590		—	—	—	SL-40-70, -80, -90
SLF-45101	.640	4.375	2.050	.420	#10-32	CENTER	—	.192	—	—	—	SL-45-10, -20, -30
SLF-45102	1.140			.920		.320	.340		—	—	—	SL-45-40, -50, -60
SLF-45103	1.640			1.420		.570	.590		—	—	—	SL-45-70, -80, -90
SLF-50101	.640	5.624	2.050	.420	#10-32	CENTER	—	.192	—	—	—	SL-50-10, -20, -30
SLF-50102	1.140			.920		.320	.340		—	—	—	SL-50-40, -50, -60
SLF-50103	1.640			1.420		.570	.590		—	—	—	SL-50-70, -80, -90
SLF-55101	.640	7.124	2.050	.420	#10-32	CENTER	—	.192	—	—	—	SL-55-10, -20, -30
SLF-55102	1.140			.920		.320	.340		—	—	—	SL-55-40, -50, -60
SLF-55103	1.640			1.420		.570	.590		—	—	—	SL-55-70, -80, -90
SLF-60101	.640	8.749	2.050	.420	#10-32	CENTER	—	.192	—	—	—	SL-60-10, -20, -30
SLF-60102	1.140			.920		.320	.340		1.995	2.379	4.183	SL-60-40, -50, -60
SLF-60103	1.640			1.420		.570	.590		—	—	—	SL-60-70, -80, -90

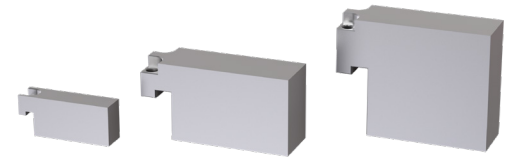
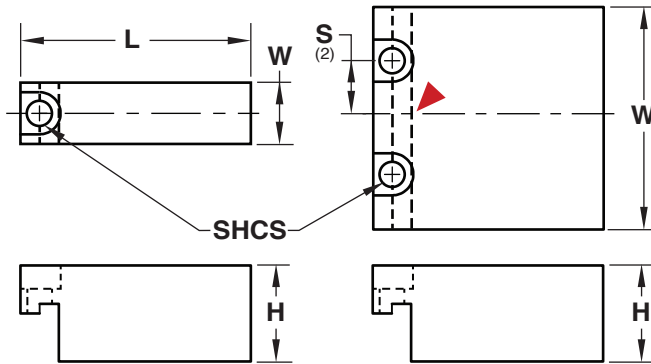
**MACHINING GUIDELINES**

- The Slide Face has .005" grinding stock per side on the gib area. The area marked "Grind" needs to be machined to fit the mating Slide.
- When assembled with the screws, there will still be a gap between the .055 slot on the Slide Face and the .070 area on the Slide.



VERSA-SLIDE

SLIDE FACES: 10 & 20 SERIES



M P-20 **H** 28-32 HRC

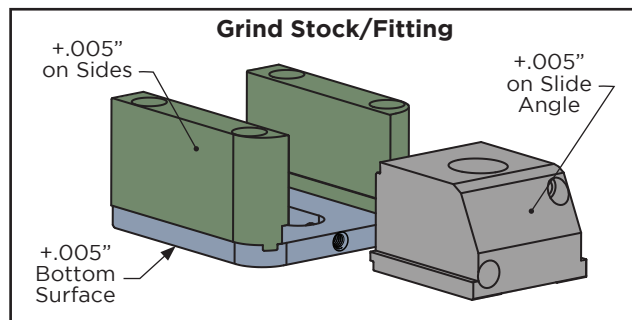
▶ CAD insertion point

CATALOG NUMBER	H ±.0005	W +.0000 -.0003	L +.005 -.000	SHCS	S1 ±.01	FOR USE WITH SLIDE ASSEMBLY
SLF-10100	.5000	.3200	1.200	#4-40	—	SL-10-10
SLF-10101		1.3200			.375	SL-10-20
SLF-20101	.4600	.6250	1.900	#5-40	.205	SL-20-10
SLF-20102	.9600					SL-20-20
SLF-20103	1.3900					SL-20-30

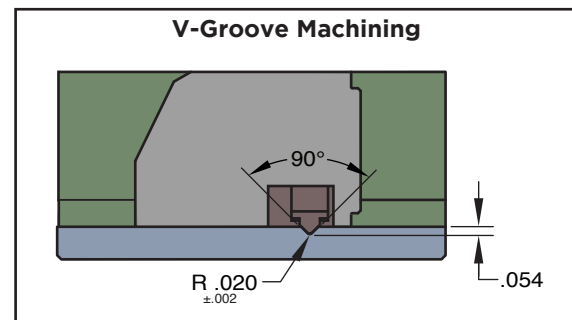
APPLICATION GUIDELINES

- The 10 & 20 Series Slide Faces are finished ground; no additional machining or fitting is required.

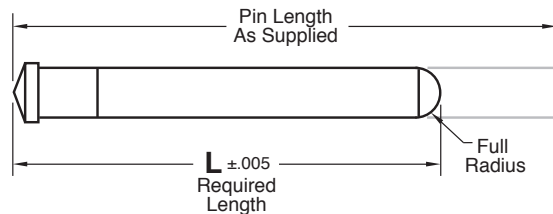
MACHINING GUIDELINES



- Grind stock is included on the Guides and bottom of the Wear Plates. Machine to fit the pockets to the W1 dimensions shown on the individual series pages.
- For the Slide, grind stock is included on the back to allow for adjustment with the mating Wedge.
- The width of the Wear Plate is undersized to fit into the pocket.



- Machine V-Groove in the top of the Wear Plates to accept the Slide Lock in all Versa-Slide assemblies 25 Series and larger.
- For the 20 Series assemblies, machine the V-Groove in the bottom of the Slide.



CAM PINS

- CP-20 (3/8 diameter) and CP-30 (1/2 diameter) Cam Pins are to be machined on the length by the mold maker to accommodate the final travel requirement.
- Mold-Ready Cam Pins are available as shown below.

STANDARD CAM PIN CATALOG NUMBER	PIN LENGTH AS SUPPLIED
CP-20	6.03
CP-30	7.05

To Order Mold-Ready Cam Pins:

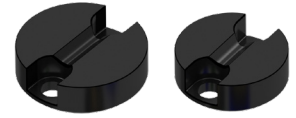
- Specify the size of the pin (CP-20 or CP-30) and the length required.
- Example: CP-30 L6.244 is a 1/2" diameter Cam Pin machined to 6.244" long with a full radius. Longer-than-standard lengths can also be quoted.
- Submit an email to tech@procomps.com with the quantity required.

SLIDE RETAINERS



Progressive's SRT® Series Slide Retainers reliably hold from 2 to 80 pounds (1 to 36 kgs) each. This slide retention design now features color-coded springs to indicate force rating. This compact design allows for installation in a mold base or wear plates.

Optional cleats may be selected or the V-Groove for roller retention may be machined in the bottom of the slide as shown on page G-25.



Inch Standard

Roller: **M** M-2 **H** 60-62 HRC **S** Titanium Nitride Coated 80 HRC

M 4140 **H** 50-54 HRC **S** Black Oxide

SLIDE RETAINERS								CLEATS				
SLIDE RETAINER CATALOG NUMBER	MAX WEIGHT PER UNIT (LBS)	D +.005 -.000	L ±.001	S ±.002	T SCREWS (2)	E MINIMUM THREAD DEPTH	SPRING COLOR	CLEAT CATALOG NUMBER	G ±.001	C ±.002	H SCREWS (2)	J MINIMUM THREAD DEPTH
SRT-02	2	.625	.160	.155	#4-48	.075	GRN	SRTC-10	.250	.190	#6-32	.250
SRT-04	4						BLU					
SRT-10	10						RED					
SRT-20	20	.750	.500	.150	#8-32	.190	GRN	SRTC-30	.250	.250	#6-32	.250
SRT-30	30						BLU					
SRT-50	50	.875	.750	.150	#8-32	.245	RED	SRTC-80	.250	.300	#6-32	.250
SRT-80	80						YEL					
SRT-40	40	1.125	.856	.205	1/4-20	.480	BLU	SRTC-75	.250	.400	#6-32	.250
SRT-60	60						RED					
SRT-75	75						YEL					

Cleats sold separately.

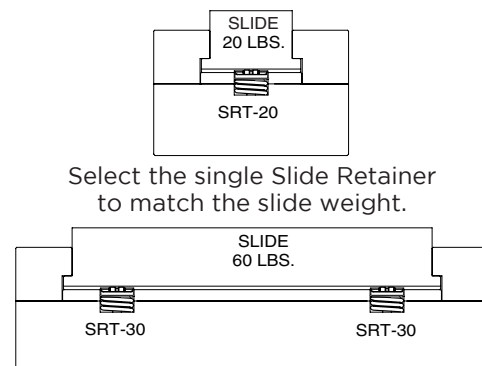
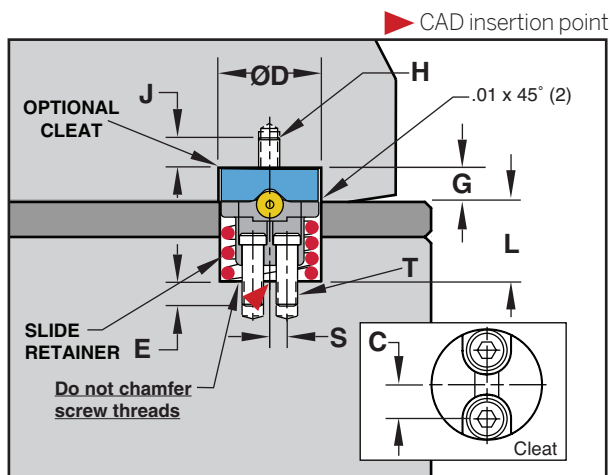
Metric Standard

Roller: **M** M-2 **H** 60-62 HRC **S** Titanium Nitride Coated 80 HRC

M 4140 **H** 50-54 HRC **S** Black Oxide

SLIDE RETAINERS								CLEATS				
SLIDE RETAINER CATALOG NUMBER	MAX WEIGHT PER UNIT (KGS)	D +.1 -.0	L ±.025	S ±.05	T SCREWS (2)	E MINIMUM THREAD DEPTH	SPRING COLOR	CLEAT CATALOG NUMBER	G ±.025	C ±.05	H SCREWS (2)	J MINIMUM THREAD DEPTH
SRTM-01	1	15.9	4.06	3.95	M3 - .5	1.9	GRN	SRTMC-04	6.35	4.85	M3 - .5	6.35
SRTM-02	2						BLU					
SRTM-04	4						RED					
SRTM-09	9	19.1	12.70	3.80	M4 - .7	4.8	GRN	SRTMC-13	6.35	6.35	M3 - .5	6.35
SRTM-13	13						BLU					
SRTM-22	22	22.3	19.05	3.80	M4 - .7	6.2	RED	SRTMC-36	6.35	7.60	M3 - .5	6.35
SRTM-36	36						YEL					
SRTM-18	18	28.2	21.75	5.20	M6 - 1.0	12.0	BLU	SRTMC-34	6.35	10.50	M3 - .5	6.35
SRTM-28	28						RED					
SRTM-34	34						YEL					

Cleats sold separately.



Select the single Slide Retainer to match the slide weight.

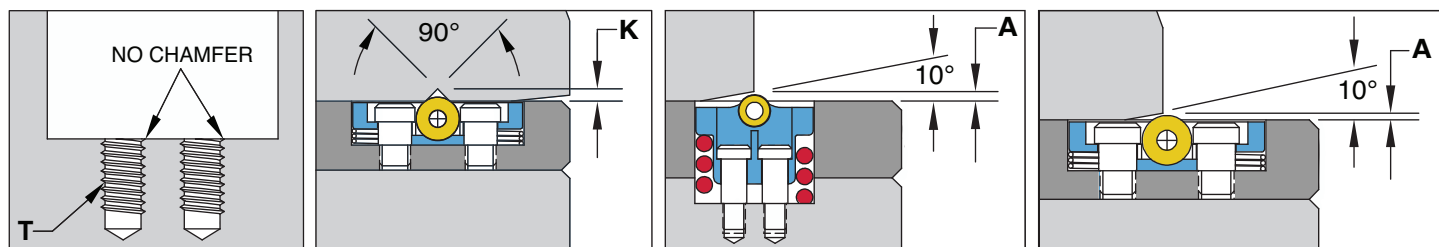
Or add the force of multiple Slide Retainers to match the slide weight.



SLIDE RETAINERS

APPLICATION GUIDELINES

- Maximum operating temperature is 425°F (220°C).
- Match total Slide Retainers Spring force to slide weight; excess spring force could induce wear.
- Do not chamfer screw threads.
- Machine 10° lead-in on all slides to aid in assembly once the SRT is installed.
- Optional Bases and Bushings shown on the following page allow for installation in plates made from materials such as aluminum, copper, and bronze and contain the screw/thread installation.



RETAINER CATALOG NUMBER	T THREAD (2)	TAP CLASS REQUIRED	K V-GROOVE	A 10° ANGLE LEAD - IN
SRT-02	#4-48	2B GH2	.041"	.02"
SRT-04				
SRT-10				
SRT-20	#8-32	2B GH3	.078"	.04"
SRT-30				
SRT-50				
SRT-80	#8-32	2B GH3	.078"	.05"
SRT-40				
SRT-60				
SRT-75	1/4-20	2B GH3	.102"	.07"
SRTM-01				
SRTM-02				
SRTM-04	M3 - .5	6H D3	1 mm	.50 mm
SRTM-09				
SRTM-13				
SRTM-22	M4 - .7	6H D4	2 mm	1.00 mm
SRTM-36				
SRTM-18				
SRTM-28	M6 - 1.0	6H D4	2.6 mm	1.85 mm
SRTM-34				

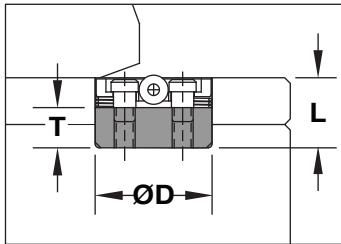


SLIDE RETAINERS

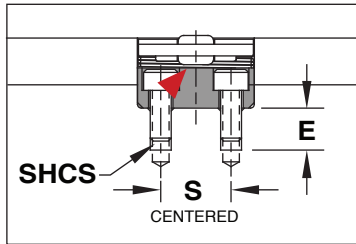
BASES & BUSHINGS



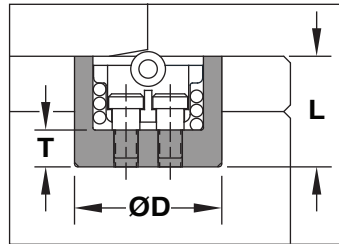
SRT BASES



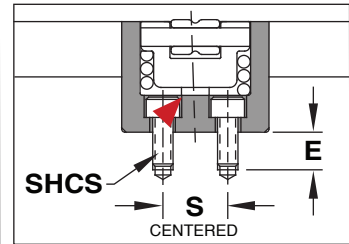
SRT Bases enable the Slide Retainer to be installed in a hardened plate when mold base steel is aluminum, for example. (SRTBA-10 shown in graphics.)



SRT BUSHINGS



SRT Bushings accept the standard Slide Retainer to allow for installation in soft materials (aluminum, copper bronze, etc). Also, the SRT Bushing can provide hardened guidance against wear rather than bearing on a bronze wear plate. (SRTBU-30 shown in graphics.)



Inch Standard

Base: **M** D-2 **H** 58-60 HRC **S** Black Oxide

Bushing: **M** D-2 **H** 58-60 HRC **S** Black Oxide

CATALOG NUMBER	D +.005 -.000	L ±.001	S ±.01	T	E REF	SHCS (2)	USE WITH	CATALOG NUMBER	D +.001 -.000	L +.002 -.000	S ±.01	T	E REF	SHCS (2)
SRTBA-10	.625	.375	.37	.215	.220	#4-40 x 5/16	SRT-02	SRTBU-10	.875	.375	.37	.215	.220	#4-40 x 5/16
							SRT-04							
							SRT-10							
SRTBA-30	.750	.750	.44	.250	.280	#6-32 x 3/8	SRT-20 SRT-30	SRTBU-30	1.000	.750	.44	.250	.280	#6-32 x 3/8
SRTBA-80	.875	1.000	.50	.250	.280	#6-32 x 3/8	SRT-50 SRT-80	SRTBU-80	1.125	1.000	.50	.250	.280	#6-32 x 3/8
SRTBA-75	1.125	1.300	.62	.443	.380	#10-32 x 1/2	SRT-40	SRTBU-75	1.500	1.300	.62	.443	.380	#10-32 x 1/2
							SRT-60							
							SRT-75							

Metric Standard

Base: **M** D-2 **H** 58-60 HRC **S** Black Oxide

Bushing: **M** D-2 **H** 58-60 HRC **S** Black Oxide

CATALOG NUMBER	D +.1 -.0	L ±.03	S ±.25	T	E REF	SHCS (2)	USE WITH	CATALOG NUMBER	D +.03 -.00	L +.05 -.00	S ±.25	T	E REF	SHCS (2)
SRTMBA-04	15.9	9.56	8	5.50	5.30	M2.5-.45 x 8	SRTM-01	SRTMBU-04	22.3	9.50	8	5.44	5.35	M2.5-.45 x 8
							SRTM-02							
							SRTM-04							
SRTMBA-13	19.1	19.05	11	6.35	4.95	M3-.5 x 8	SRTM-09	SRTMBU-13	25.4	19.10	11	6.35	4.95	M3-.5 x 8
							SRTM-13							
SRTMBA-36	22.3	25.40	13	6.35	4.95	M3-.5 x 8	SRTM-22	SRTMBU-36	28.5	25.40	13	6.35	4.95	M3-.5 x 8
							SRTM-36							
SRTMBA-34	28.2	33.00	16	11.25	9.90	M5-.8 x 12	SRTM-18	SRTMBU-34	37.0	33.00	16	11.25	9.90	M5-.8 x 12
							SRTM-28							
							SRTM-34							

▶ CAD insertion point

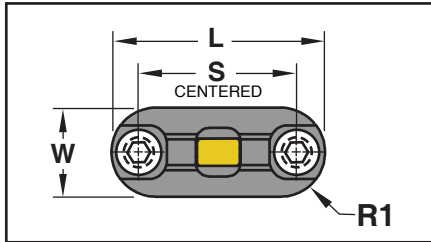


SLIDE RETAINERS

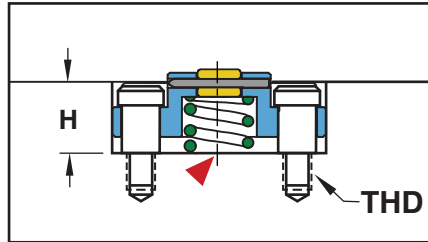
SLIDE LOCK STYLE

Slide Lock Style slide retention is offered in sizes compatible with previous standards, and Progressive's now provides smooth, greaseless friction-free performance.

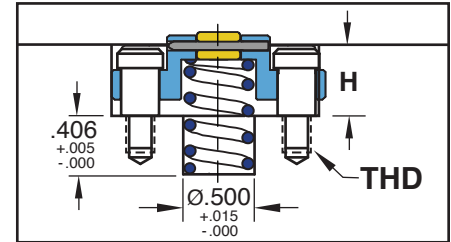
Reliably holding 25 to 50 pounds each, this design features color-coded springs to indicate force rating.



SRTLK-25A & SRTLK-50A



SRTLK-25B



Roller: **M** M-2 **H** 60-62 HRC **S** Titanium Nitride Coated 80 HRC

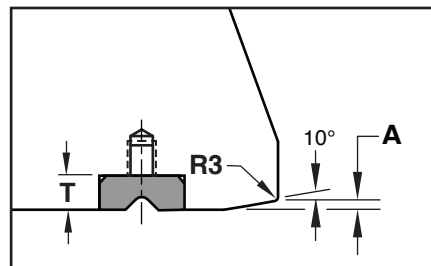
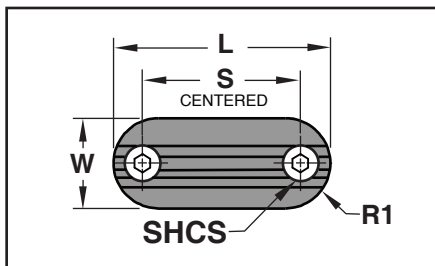
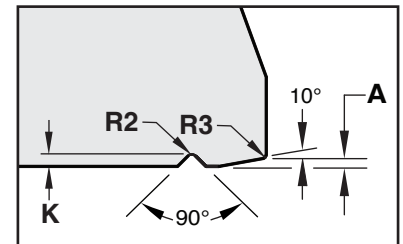
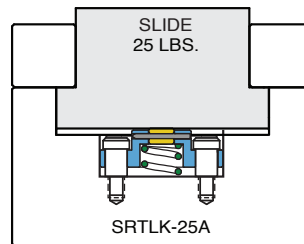
SLIDE RETAINER CATALOG NUMBER	MAX WEIGHT PER UNIT (LBS)	SPRING COLOR	L +.004 -.000	W +.004 -.000	H +.002 -.000	R1 +.002 -.000	THD	S	A	K	R2	R3
SRTLK-25A	25	GRN	1.500	.625	.500	.312	#6-32	1.100	.070	.100	.047	.03
SRTLK-25B	25	BLU										
SRTLK-50A	50	RED	2.300	1.000	.875	.500	1/4-20	1.650	.100	.155	.079	.05

► CAD insertion point

Pocket dimensions shown. Screws included.

APPLICATION GUIDELINES

- Select the single Slide Retainer to match the slide weight. Multiple retainers may be used for heavier slides.
- Machine the pockets as shown in the graphics and table.
- For retention on the slide, purchase the Cleats as shown below or machine the groove in the slide as shown at right.



CLEATS

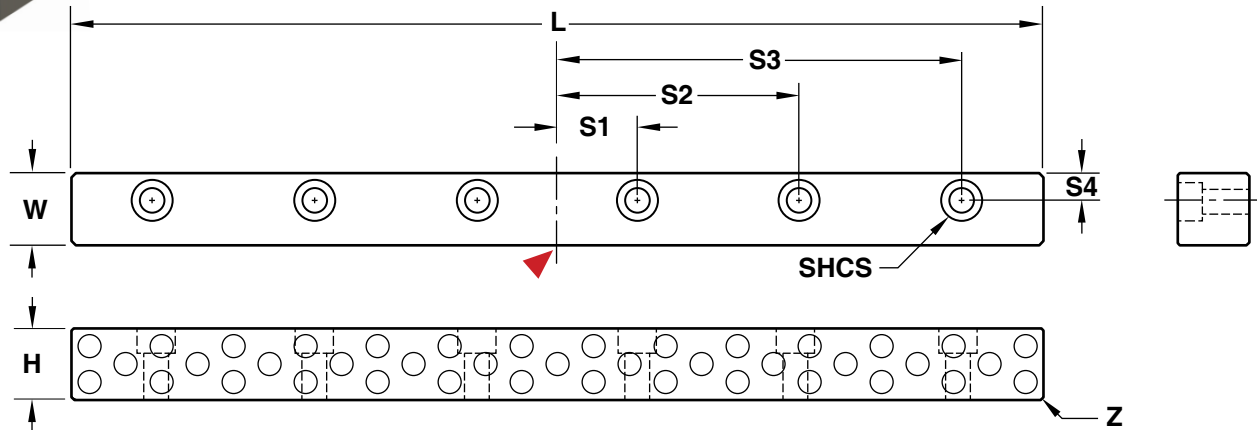
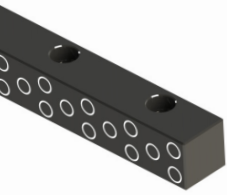


M 4140 **H** 50-54 HRC **S** Black Oxide

CLEAT CATALOG NUMBER	L +.004 -.000	W +.004 -.000	T +.002 -.000	R1 +.002 -.000	R3	SHCS	S
SRTLK-25A-C	1.500	.625	.250	.312	.03	#6-32 x 1/4	1.100
SRTLK-50A-C	2.300	1.000	.400	.500	.05	1/4-20 x 3/8	1.650

Pocket dimensions shown. Screws included.

SQUARE GIBS



M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

CAD insertion point

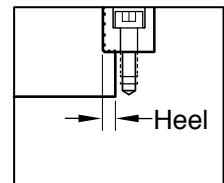
CATALOG NUMBER	W +.0005 -.0000	H +.000 -.005	L ±.005	NUMBER OF SCREW HOLES	Z CHAMFER	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01	SHCS
SG50L6	.502	.495	6.00	4	.03	.75	2.25	—	.18	#8-32 x 1/2
SG50L10.5			10.50	6		.88	2.63	4.38		
SG75L10	.752	.745	10.00	4	.04	1.25	3.75	—	.25	1/4-20 x 7/8
SG75L13.5			13.50	6		1.13	3.38	5.63		
SG100L10	1.002	.995	10.00	4	.04	1.25	3.75	—	.37	5/16-18 x 1-1/8
SG100L13.5			13.50	6		1.13	3.38	5.63		

Screws included.

APPLICATION GUIDELINES

- Square Gibs are designed to be cut-to-length to make two Gibs out of one bar.
- The maximum heel size for each Square Gib is shown at right.

SIZE	HEEL
SG50	.125
SG75	.250
SG100	.312



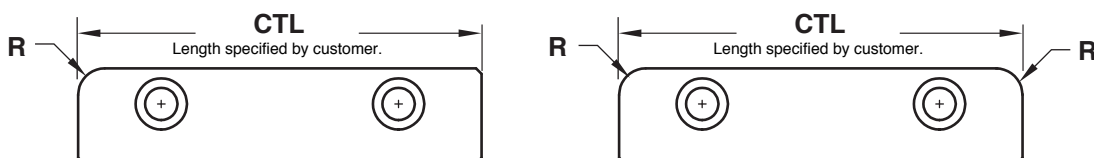
MOLD-READY GIBS

To Order:

Start with the prefix and the size from above. Example: SG75

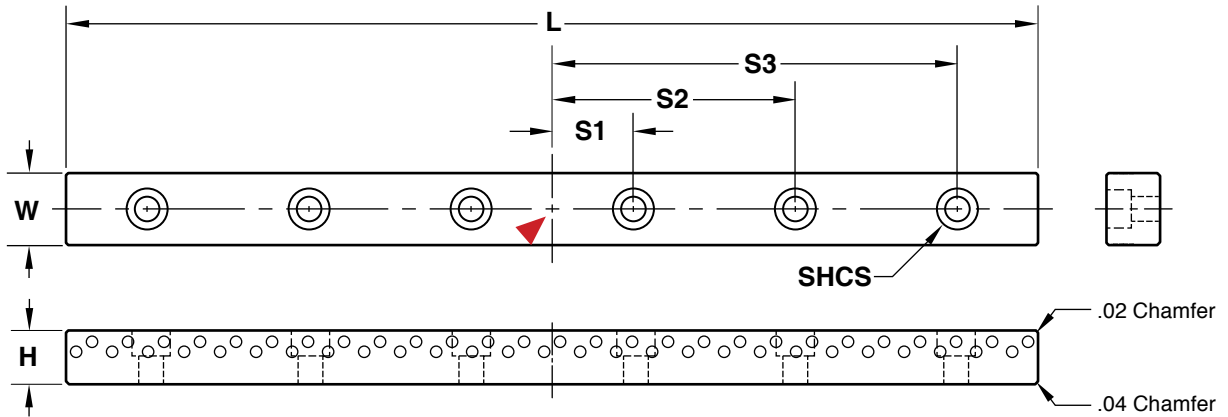
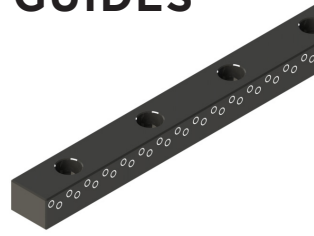
- For Gibs with no radii and cut-to-length, specify the length (CTL). Example: SG75L4.25
- For 1 corner radius as shown below left, specify the length followed by the 1R designation and then the required pocket radius. (The actual radius will be larger for clearance.) Example: SG75L4.25-1R.312
- For 2 corner radii as shown below right, specify the length followed by the 2R designation and then the required pocket radius. (The actual radii will be the same and will be larger for clearance.) Example: SG75L4.25-2R.312
- Submit the item number and quantity to Customer Service for a quotation.

Note: Screw sizes and locations will be the same as the standard Gibs. Any specifications outside of the modifications above can be quoted made-to-order by contacting tech@procomps.com.





CENTER GUIDES



M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

▶ CAD insertion point

CATALOG NUMBER	W +.0000 -.0005	H +.000 -.005	L ±.005	NUMBER OF SCREW HOLES	S1 ±.01	S2 ±.01	S3 ±.01	SHCS
CG50X62L6	.4998	.620	6.00	4	.75	2.25	—	#8-32 x 3/4
CG50X62L10.5			10.50	6	.88	2.63	4.38	
CG75X62L10	.7498	.620	10.00	4	1.25	3.75	—	1/4-20 x 3/4
CG75X62L13.5			13.50	6	1.13	3.38	5.63	
CG100X75L10	.9998	.745	10.00	4	1.25	3.75	—	5/16-18 x 7/8
CG100X75L13.5			13.50	6	1.13	3.38	5.63	

Screws included.

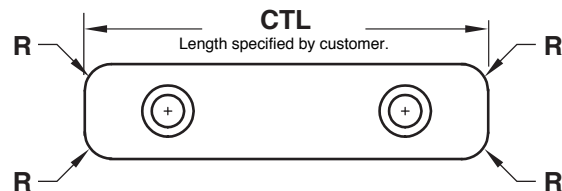
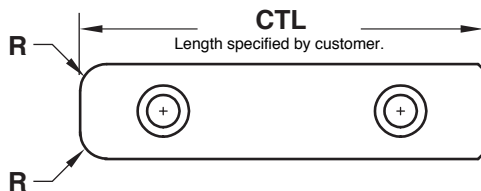
MOLD-READY GUIDES

To Order:

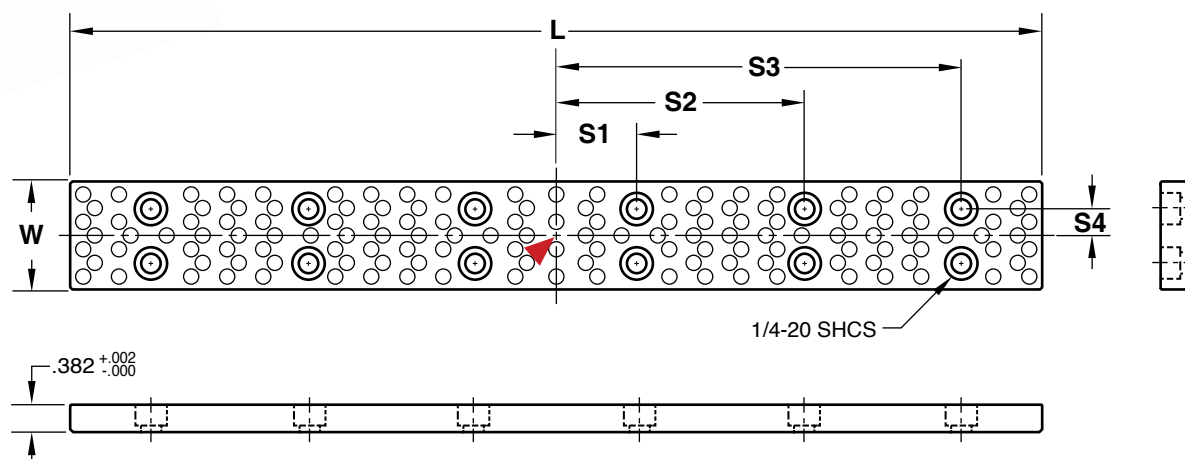
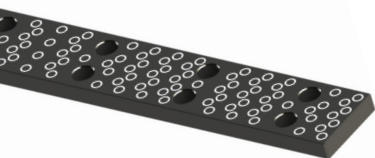
Start with the prefix and the size from above. Example: CG50X62

- For Guides with no radii and cut-to-length, specify the length (CTL). Example: CG50X62L4.25
- For 2 corner radii as shown below left, specify the length followed by the 2R designation and then the required pocket radius. (The actual radius will be larger for clearance.) Example: CG50X62L4.25-2R.312
- For 4 corner radii as shown below right, specify the length followed by the 4R designation and then the required pocket radius. (The actual radii will be the same and will be larger for clearance.) Example: CG50X62L4.25-4R.312
- Submit the item number and quantity to Customer Service for a quotation.

Note: Screw sizes and locations will be the same as the standard Guides. Any specifications outside of the modifications above can be quoted made-to-order by contacting tech@procomps.com.



WEAR STRIPS



M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

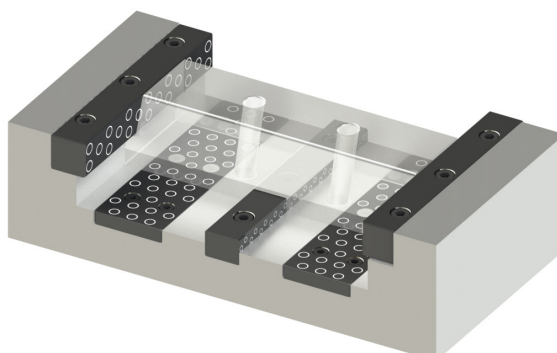
CATALOG NUMBER	W +.000 -.002	L ±.005	NUMBER OF SCREW HOLES	S1 ±.01	S2 ±.01	S3 ±.01	S4 ±.01
WS75L6	.749	6.00	4	.75	2.25	—	—
WS75L10.5		10.50	6	.88	2.63	4.38	—
WS100L10	.999	10.00	4	1.25	3.75	—	—
WS100L13.5		13.50	6	1.13	3.38	5.63	—
WS150L10	1.499	10.00	8	1.25	3.75	—	.375
WS150L13.5		13.50	12	1.13	3.38	5.63	
WS200L10	1.999	10.00	8	1.25	3.75	—	.500
WS200L13.5		13.50	12	1.13	3.38	5.63	

► CAD insertion point

1/4-20 x 1/2" long screws included.

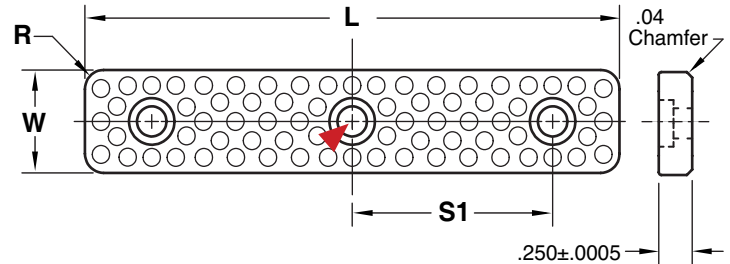
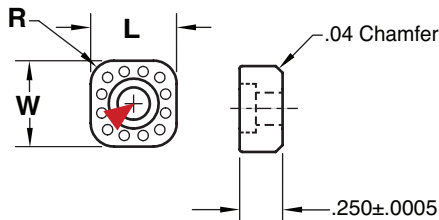
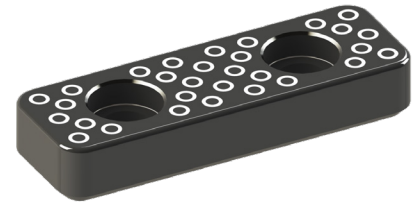
APPLICATION GUIDELINES

- Wear Strips can be cut to use in multiple areas and can be used in tandem with other Z-Series products as shown in the graphic below.
- For finish-machined Wear Plate options, refer to page G-31.





WEAR PLATES



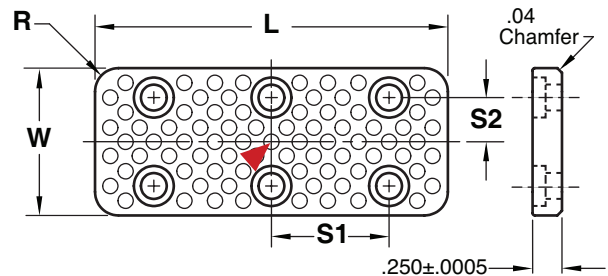
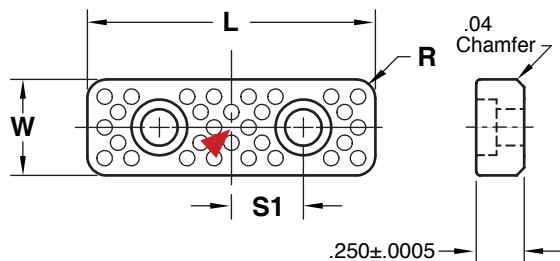
M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

CATALOG NUMBER	W +.000 -.005	L +.000 -.005	R POCKET RADIUS	LHCS
WP050X050	.500	.500	.125	#8-32 x 3/8

► CAD insertion point

M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

CATALOG NUMBER	W +.000 -.005	L +.000 -.005	S1 ±.01	R POCKET RADIUS	LHCS
WP050X250	.500	2.500	.87	.094	#8-32 x 3/8
WP050X350		3.500	1.37		
WP075X400	.750	4.000	1.50	.125	#10-32 x 3/8
WP075X600		6.000	2.50		

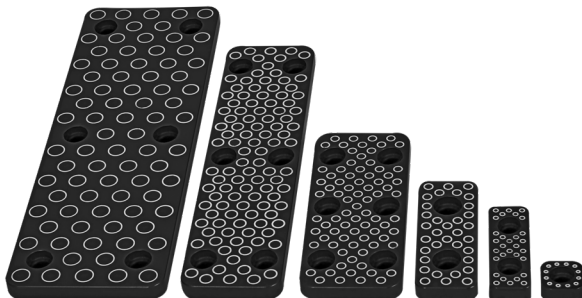


M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

CATALOG NUMBER	W +.000 -.005	L +.000 -.005	S1 ±.01	R POCKET RADIUS	LHCS
WP050X150	.500	1.500	.37	.094	#8-32 x 3/8
WP075X200	.750	2.000	.50	.125	#10-32 x 3/8

M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride

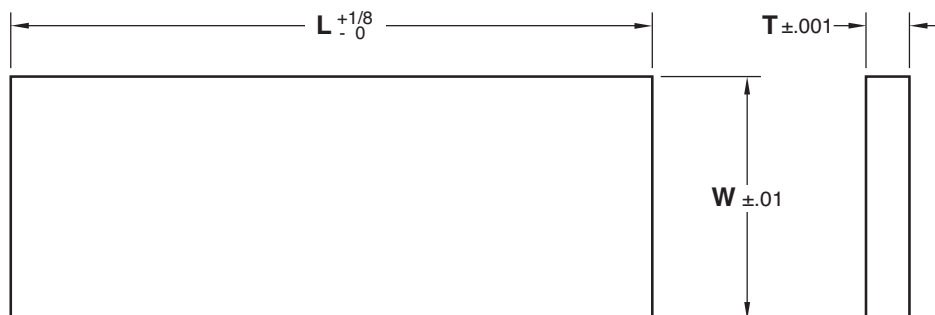
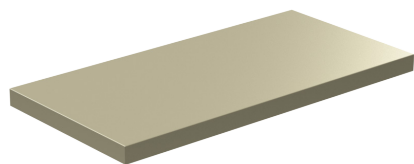
CATALOG NUMBER	W +.000 - .005	L +.000 - .005	S1 ±.01	S2 ±.01	R POCKET RADIUS	LHCS
WP125X300	1.250	3.000	1.00	.37	.187	#10-32 x 3/8
WP125X500	1.250	5.000	2.00	.37		
WP125X800	1.250	8.000	3.50	.37		
WP200X600	2.000	6.000	2.50	.62		
WP200X800	2.000	8.000	3.50	.62		
WP250X600	2.500	6.000	2.50	.75		
WP300X600	3.000					



APPLICATION GUIDELINES

- Standardized design is ready to install.
- Wear Plates can be cut as long as the edges have radii.
- Low Head Cap Screws included.

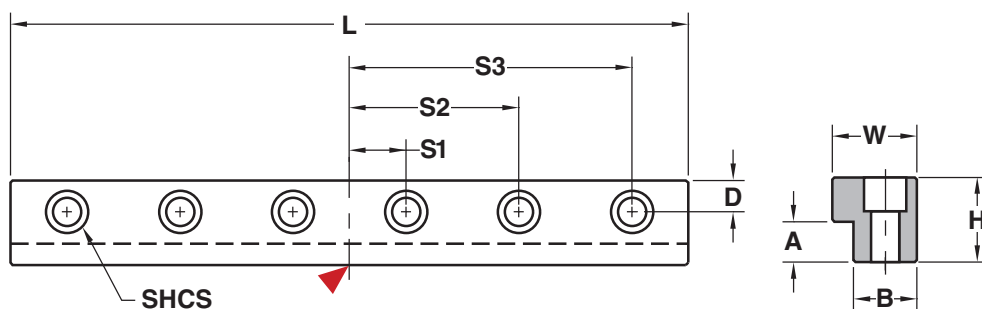
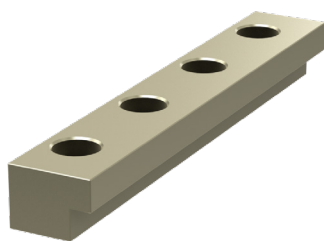
BRONZE WEAR PLATES



M CA954 Solid Bronze **H** 170 Brinell

T	W	L=4"	L=5"	L=6"	L=8"	L=10"	L=12"
1/4	1.000	WP25X1X4	WP25X1X5	WP25X1X6	WP25X1X8	WP25X1X10	WP25X1X12
	1.500	WP25X1.5X4	WP25X1.5X5	WP25X1.5X6	WP25X1.5X8	WP25X1.5X10	WP25X1.5X12
	2.000	WP25X2X4	WP25X2X5	WP25X2X6	WP25X2X8	WP25X2X10	WP25X2X12
	2.500	WP25X2.5X4	WP25X2.5X5	WP25X2.5X6	WP25X2.5X8	WP25X2.5X10	WP25X2.5X12
	3.000	WP25X3X4	WP25X3X5	WP25X3X6	WP25X3X8	WP25X3X10	WP25X3X12
	4.000	WP25X4X4	WP25X4X5	WP25X4X6	WP25X4X8	WP25X4X10	WP25X4X12
3/8	1.000	WP37X1X4	WP37X1X5	WP37X1X6	WP37X1X8	WP37X1X10	WP37X1X12
	1.500	WP37X1.5X4	WP37X1.5X5	WP37X1.5X6	WP37X1.5X8	WP37X1.5X10	WP37X1.5X12
	2.000	WP37X2X4	WP37X2X5	WP37X2X6	WP37X2X8	WP37X2X10	WP37X2X12
	2.500	WP37X2.5X4	WP37X2.5X5	WP37X2.5X6	WP37X2.5X8	WP37X2.5X10	WP37X2.5X12
	3.000	WP37X3X4	WP37X3X5	WP37X3X6	WP37X3X8	WP37X3X10	WP37X3X12
	4.000	WP37X4X4	WP37X4X5	WP37X4X6	WP37X4X8	WP37X4X10	WP37X4X12

L-GIBS



M CA954 Solid Bronze **H** 170 Brinell

CAD insertion point

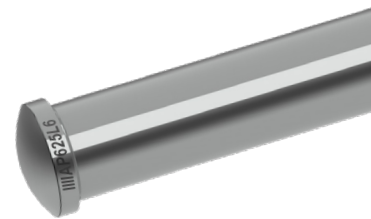
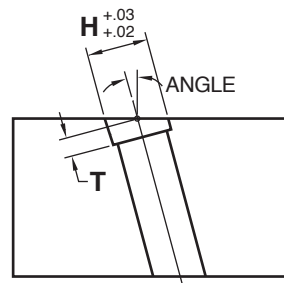
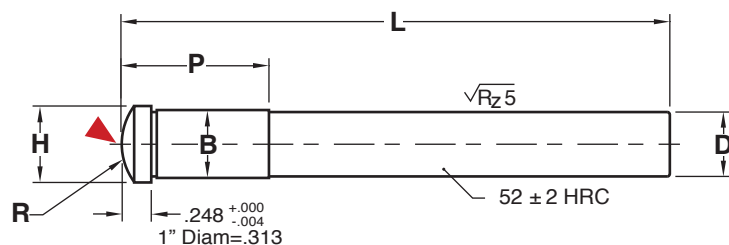
CATALOG NUMBER	W +.002 -.000	L ±.010	H ±.005	A +.002 -.000	B +.002 -.000	NUMBER OF SCREW HOLES	SHCS	S1 ±.01	S2 ±.01	S3 ±.01	D
LGIB75L5.25	.750	5.25	.745	.312	.563	3	1/4	1.62	—	—	.281
LGIB75L8.75	.750	8.75	.745	.312	.563	4	1/4	1.00	3.37	—	.281
LGIB100L6	1.000	6.00	.745	.375	.750	4	5/16	.75	2.25	—	.375
LGIB100L10	1.000	10.00	.745	.375	.750	4	5/16	1.25	3.75	—	.375
LGIB125L6	1.250	6.00	.870	.500	.875	4	3/8	.75	2.25	—	.438
LGIB125L10	1.250	10.00	.870	.500	.875	4	3/8	1.25	3.75	—	.438
LGIB150L9	1.500	9.00	1.245	.750	1.000	4	3/8	1.12	3.37	—	.500
LGIB150L15	1.500	15.00	1.245	.750	1.000	6	3/8	1.25	3.75	6.25	.500

To Order Undrilled L-Gibs:

- Specify "N" at the end of the catalog number. Example: LGIB150L9N.



ANGLE PINS

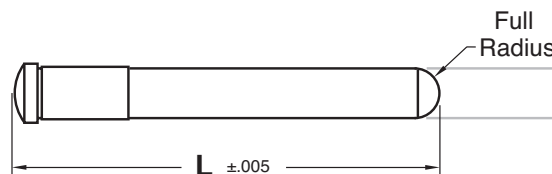


M 8620 **H** Surface: 50-54 HRC

▶ CAD insertion point

NOMINAL DIAMETER	CATALOG NUMBER	D +.0000 -.0005	L +1/8 -0	B +.0005 -.0000	H +.000 -.010	R HEAD RADIUS	P PRESS FIT LENGTH	ANGLE	T DEPTH
3/8	AP375L6	.374	6	.376	.500	.375	.75	10°	.258
	AP375L10		10				1.25	15°	.265
								20°	.276
1/2	AP500L6	.499	6	.501	.625	.500	.75	25°	.291
	AP500L10		10				1.25	10°	.260
								15°	.270
5/8	AP625L6	.624	6	.626	.750	.625	.75	20°	.284
	AP625L10		10				1.25	25°	.304
								10°	.262
3/4	AP750L10	.749	10	.751	.875	.750	1.25	15°	.274
	AP750L14		14					20°	.292
								25°	.316
1	AP1000L10	.999	10	1.001	1.118	1.000	1.31	10°	.264
	AP1000L14		14					15°	.278
								20°	.300
								25°	.329
								10°	.332
								15°	.352
								20°	.381
								25°	.420

MOLD-READY ANGLE PINS



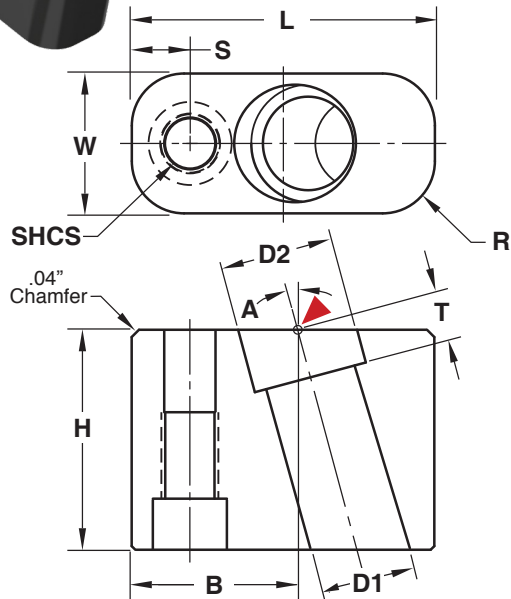
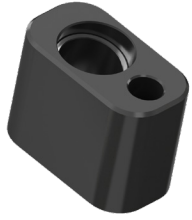
To Order:

- A full radius option can be ordered by specifying the prefix of "APR" and the diameter as outlined above, plus "L" and the length required.
- Example: APR625L7.244 (no dashes/spaces) is an Angle Pin with a 5/8" diameter machined to 7.244" long with a full radius.
- Note: P will remain as shown in table above.

APR - 625 - L7.244
Prefix Pin Diameter Length Specified to 3 decimals

ANGLE PIN HOLDERS

IN-LINE BOLT

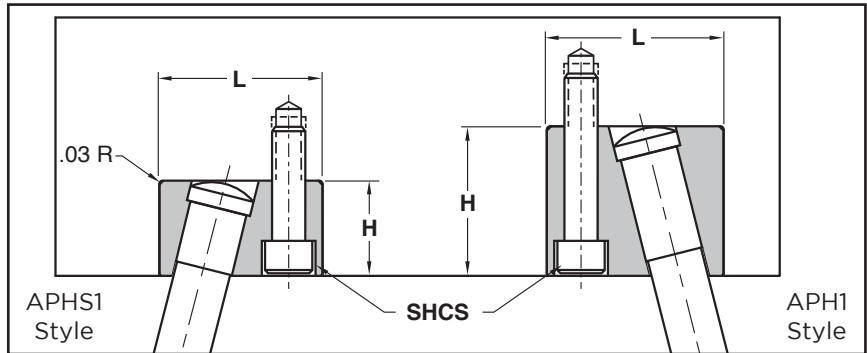


APPLICATION GUIDELINES

- Angle Pin Holders are provided with 10°, 15°, or 20° angles and allow for machining and installation from parting line.
- The In-Line Single Bolt version has a narrow design where space is limited.
- Angle Pins are sold separately on page G-33.
- Includes (1) Socket Head Cap Screw as shown in the chart.

Installation:

- Machine pockets to nominal sizes as shown in chart.
- Install Angle Pin from top of Holder.
- Place entire unit in plate and fasten with the screw.



M 4140 **H** 28-32 HRC **S** Black Oxide

CAD insertion point

CATALOG NUMBER	ANGLE PIN DIA.	H +.000 - .003	L +.000 - .001	W +.000 - .001	R	S ± .01	A ANGLE	T	B	D1 ±.0002	D2 +.005 - .000	SHCS
APHS1-37-10	3/8	.875	1.250	.625	.187	.31	10°	.258	.813	.3764	.505	1/4-20 x 1
APH1-37-10		1.375	1.375				1/4-20 x 1-1/2					
APHS1-37-15		.875	1.375				1/4-20 x 1					
APH1-37-15		1.375	1.500				1/4-20 x 1-1/2					
APHS1-37-20		.875	1.500				1/4-20 x 1					
APH1-37-20		1.375	1.625				1/4-20 x 1-1/2					
APHS1-50-10	1/2	.875	1.375	.750	.250	.31	10°	.260	.875	.5014	.630	1/4-20 x 1
APH1-50-10		1.375	1.500				1/4-20 x 1-1/2					
APHS1-50-15		.875	1.500				1/4-20 x 1					
APH1-50-15		1.375	1.625				1/4-20 x 1-1/2					
APHS1-50-20		.875	1.625				1/4-20 x 1					
APH1-50-20		1.375	1.750				1/4-20 x 1-1/2					
APHS1-63-10	5/8	.875	1.625	.875	.313	.37	10°	.262	1.063	.6264	.755	5/16-18 x 1
APH1-63-10		1.375	1.750				5/16-18 x 1-1/2					
APHS1-63-15		.875	1.750				5/16-18 x 1					
APH1-63-15		1.375	1.875				5/16-18 x 1-1/2					
APHS1-63-20		.875	1.875				5/16-18 x 1					
APH1-63-20		1.375	2.000				5/16-18 x 1-1/2					
APH1-75-10	3/4	1.500	2.000	1.000	.375	.37	10°	.264	1.188	.7514	.885	3/8-16 x 1-5/8
APH1-75-15			2.125				15°	.278				
APH1-75-20			2.250				20°	.300				
APH1-100-10	1	1.500	2.625	1.500	.375	.50	10°	.332	1.500	1.0014	1.134	1/2-13 x 1-3/4
APH1-100-15			2.750				15°	.352				
APH1-100-20			2.875				20°	.381				



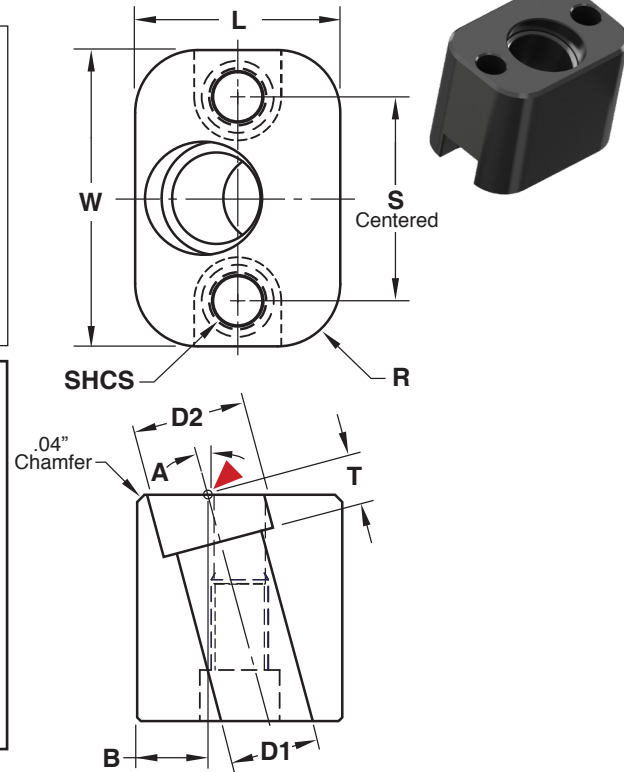
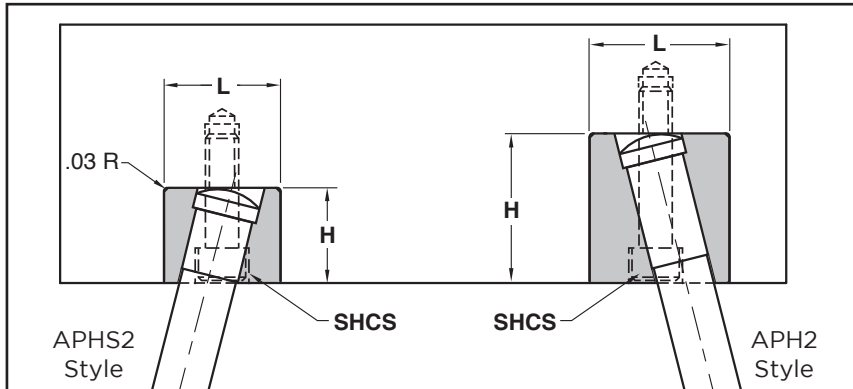
ANGLE PIN HOLDERS OUTER BOLTS

APPLICATION GUIDELINES

- The Outer Bolt version installs with two screws and only takes up a minimal amount of space behind the pin.
- Includes (2) Socket Head Cap Screws as shown in the chart.
- Angle Pins are sold separately on page G-33.

Installation:

1. Machine pockets to nominal sizes as shown in chart.
2. Install Angle Pin from top of Holder.
3. Place entire unit in plate and fasten with the screws.

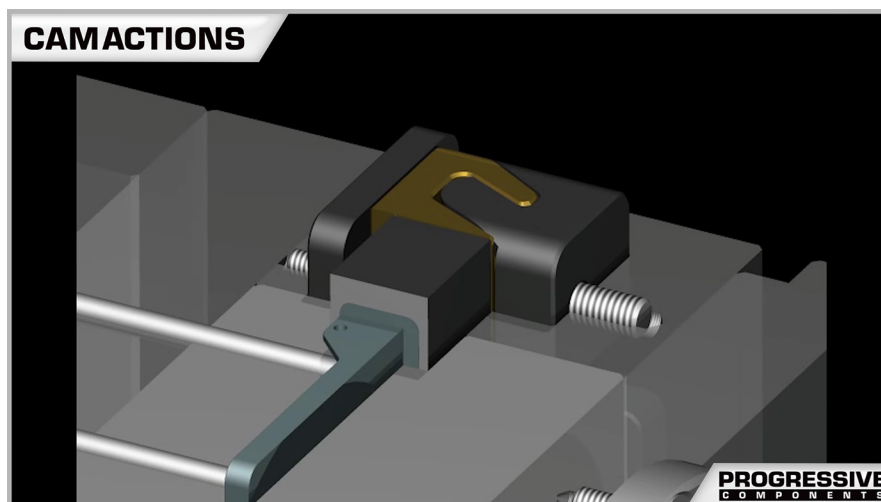


▶ CAD insertion point

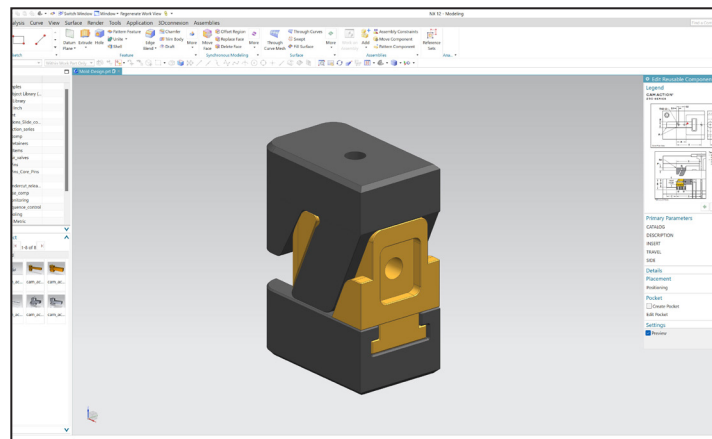
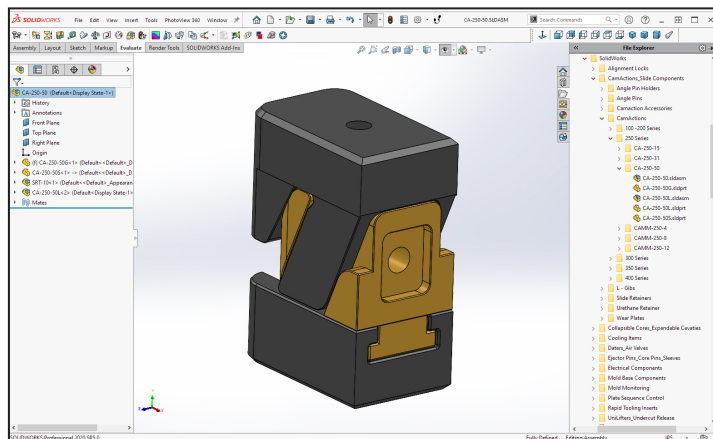
M 4140 **H** 28-32 HRC **S** Black Oxide

CATALOG NUMBER	ANGLE PIN DIA.	H +.000 - .003	L +.000 - .001	W +.000 - .001	R	S ± .01	A ANGLE	T	B	D1 ±.0002	D2 +.005 - .000	SHCS
APHS2-37-10	3/8	.875	.750	1.500	.250	1.00	10°	.258	.312	.3764	.505	1/4-20 x 1
APH2-37-10		1.375	.875				1/4-20 x 1-1/2					
APHS2-37-15		.875	.875				1/4-20 x 1					
APH2-37-15		1.375	1.000				1/4-20 x 1-1/2					
APHS2-37-20		.875	1.000				1/4-20 x 1					
APH2-37-20		1.375	1.125				1/4-20 x 1-1/2					
APHS2-50-10	1/2	.875	.875	1.625	.313	1.12	10°	.260	.375	.5014	.630	1/4-20 x 1
APH2-50-10		1.375	1.000				1/4-20 x 1-1/2					
APHS2-50-15		.875	1.000				1/4-20 x 1					
APH2-50-15		1.375	1.125				1/4-20 x 1-1/2					
APHS2-50-20		.875	1.125				1/4-20 x 1					
APH2-50-20		1.375	1.250				1/4-20 x 1-1/2					
APHS2-63-10	5/8	.875	1.125	1.875	.375	1.37	10°	.262	.500	.6264	.755	5/16-18 x 1
APH2-63-10		1.375	1.250				5/16-18 x 1-1/2					
APHS2-63-15		.875	1.250				5/16-18 x 1					
APH2-63-15		1.375	1.375				5/16-18 x 1-1/2					
APHS2-63-20		.875	1.375				5/16-18 x 1					
APH2-63-20		1.375	1.500				5/16-18 x 1-1/2					
APH2-75-10	3/4	1.500	1.375	2.000	.375	1.50	10°	.264	.563	.7514	.885	5/16-18 x 1-5/8
APH2-75-15			1.500				15°	.278				
APH2-75-20			1.625				20°	.300				
APH2-100-10	1	1.500	1.875	2.625	.375	2.00	10°	.332	.750	1.0014	1.134	3/8-16 x 1-3/4
APH2-100-15			2.000				15°	.352				
APH2-100-20			2.125				20°	.381				

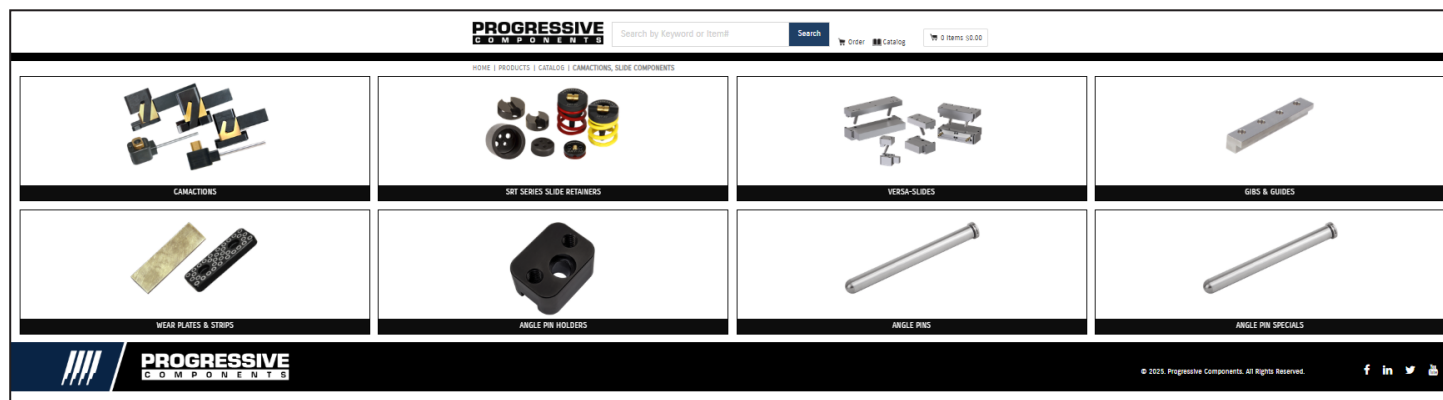
ONLINE RESOURCES



When considering design options, numerous animations can be viewed at procomps.com/animations.



CAD geometry is available online as individual downloads or as part of the CADalog system. The seven formats include: IGES (.igs), ACIS (.sat), STEP (.step), Parasolid (.x_t), SolidWorks (.sldasm), NX (.prt) (Re-Use and MoldWizard) and Visi (.wkf).



Industry-leading web store expedites the purchasing process. Go to shop.procomps.com for information and additional resources.